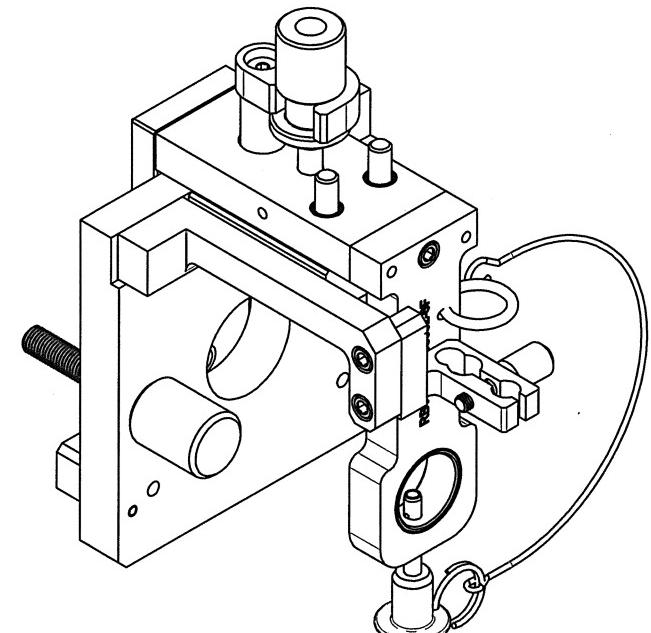
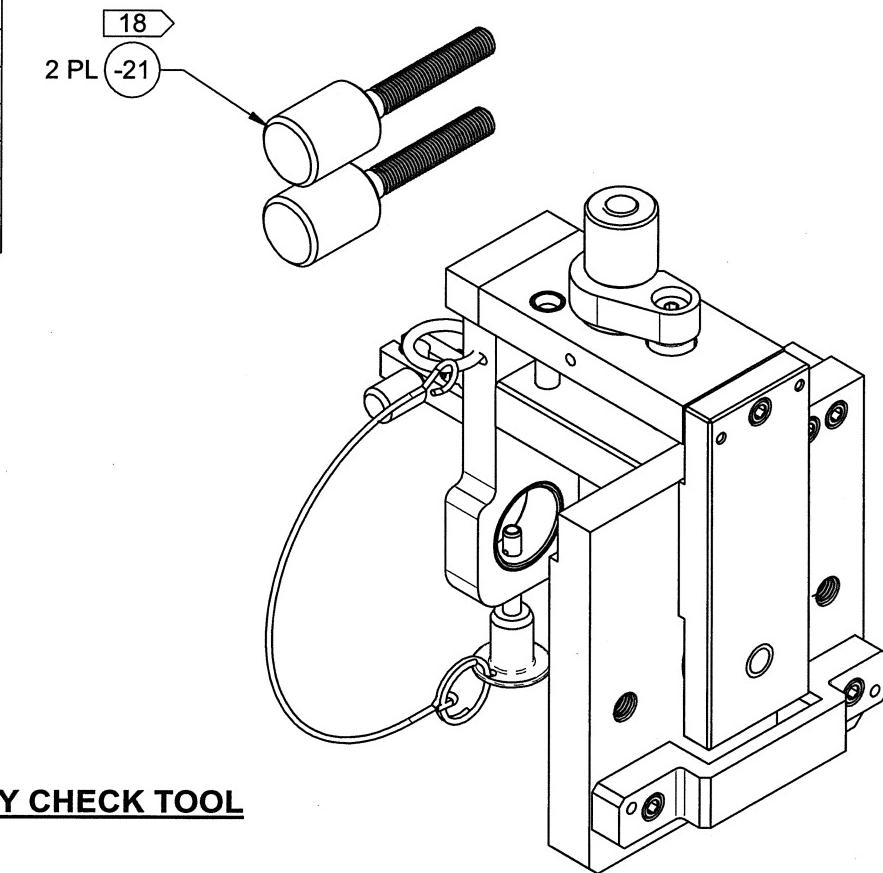


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6000G06032-6F-1	TOP PLATE ASSY
-5	1	RBW6000G06032-6F-5	SLIDING TOP PLATE ASSY
-7	1	RBW6000G06032-6F-7	ALIGNMENT SIDE PLATE ASSY
-10	1	RBW6000G06032-6F-10	ALIGNMENT PLATE ASSY
-13	1	RBW6000G06032-6F-13	SLIDING SIDE PLATE ASSY
-15	1	RBW6000G06032-6F-15	SLIDING ALIGNMENT
-16	1	RBW6000G06032-6F-16	EXTENSION ARM
-17	1	RBW6000G06032-6F-17	ARM ALIGNMENT
-18	1	RBW6000G06032-6F-18	CLAMP
-19	1	RBW6000G06032-6F-19	ADJUSMENT NUT
-20	1	RBW6000G06032-6F-20	ALIGNMENT SCREW
-21	2	RBW6000G06032-6F-21	SCREW
22	10	McMaster#91864A033 OR EQUIV	STEEL BLACK OXIDE SOCKET HEAD SCREW #8-32 X 9/16" LG.
23	1	McMaster#92012A544 OR EQUIV	ALLOY STEEL PRECISION SHOULDER SCREW #10-32 X 1/4" SHOULDER DIA. X 1-1/4" SHOULDER LENGTH
24	1	McMaster#90177A216 OR EQUIV	ZINC PLATED STEEL SPLIT RING 3/4" OD. X 5/8" ID. X 1/8" THK
25	1	McMaster#30345T961 OR EQUIV	NYLON COATED SS18-8 LANYARD 1/16" DIA. X 6" LG.
26	1	MS17984C309	SS QUICK RELEASE PIN 3/16" DIA. X 0.830" LG.



RBW6000G06032-6F RADIAL PLAY CHECK TOOL

19

NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 23 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS

9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS

10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS

11) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -16, AND REMOVE EXCESS

12) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -17, AND REMOVE EXCESS

13) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -13, AND REMOVE EXCESS

14) INSTALL ITEM 22 HAND TIGHT

15) ITEM -5, ITEM -13 AND ITEM -15 MUST SLIDE FREELY

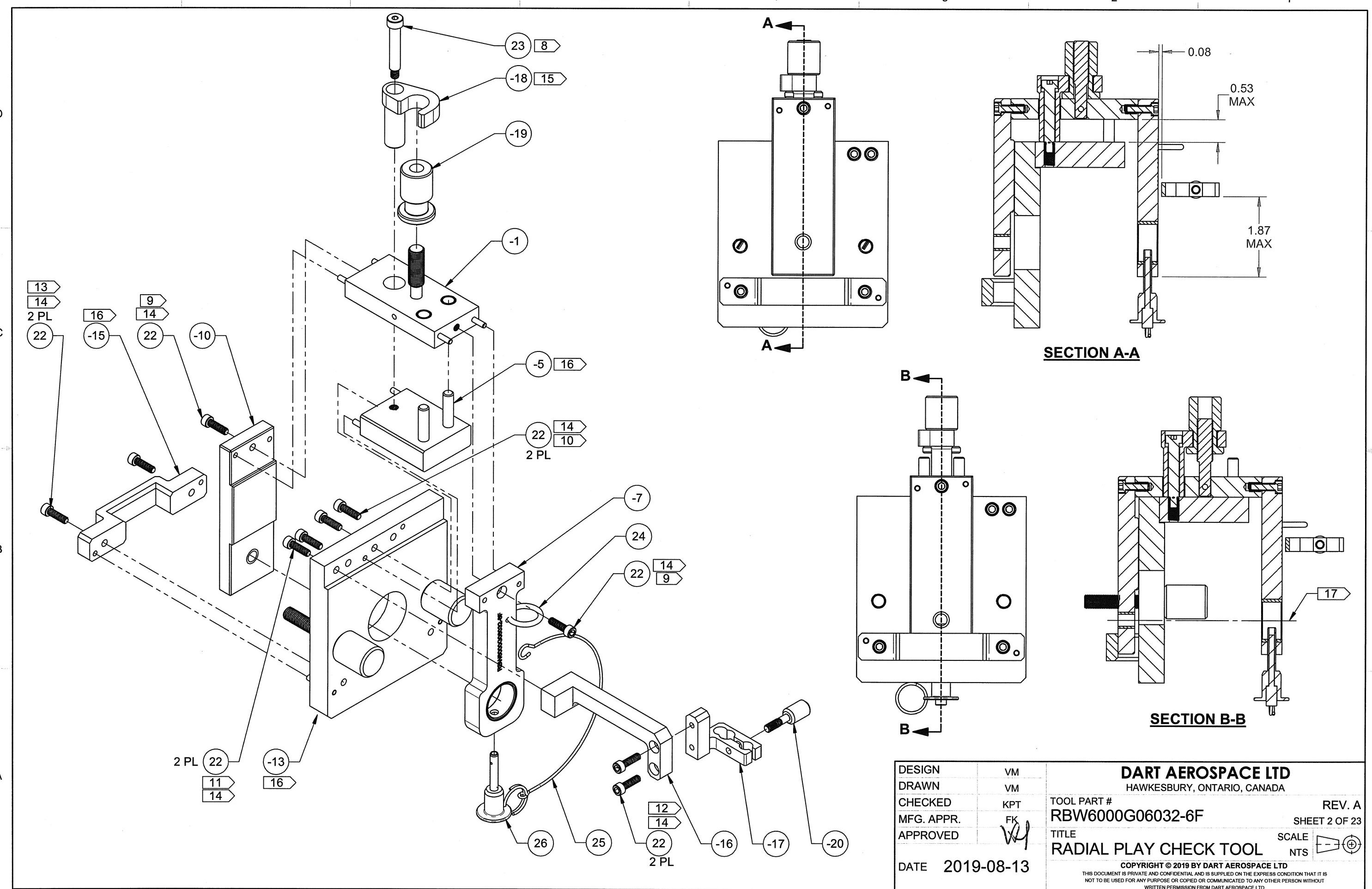
16) ITEM -5, ITEM -13 AND ITEM -15 MUST SLIDE FREELY

17) HOLES MUST ALIGN IN CLOSE POSITION

18) ITEM -21 MUST BE PACKAGED INDIVIDUALLY WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

19) TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-850	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RBW6000G06032-6F	
APPROVED	VJ	REV. A	
DATE 2019-08-13		SHEET 1 OF 23	
TITLE RADIAL PLAY CHECK TOOL		SCALE	NTS
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**DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED**

DATE 2019-08-13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ON
TOOL PART #
RBW6000G06032-6F

TITLE

RADIAL PLAY CHECK TOOL

REV. A
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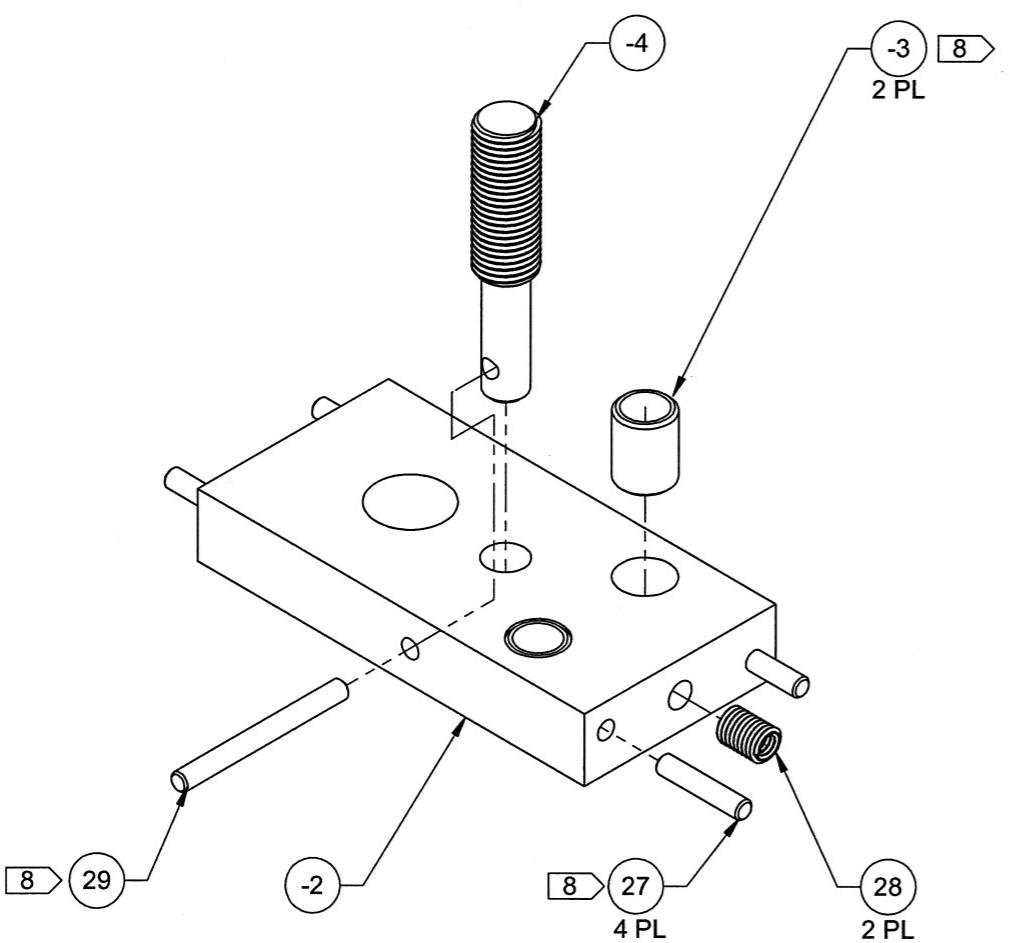
SHEET 2 OF 25

SCALE
NTS

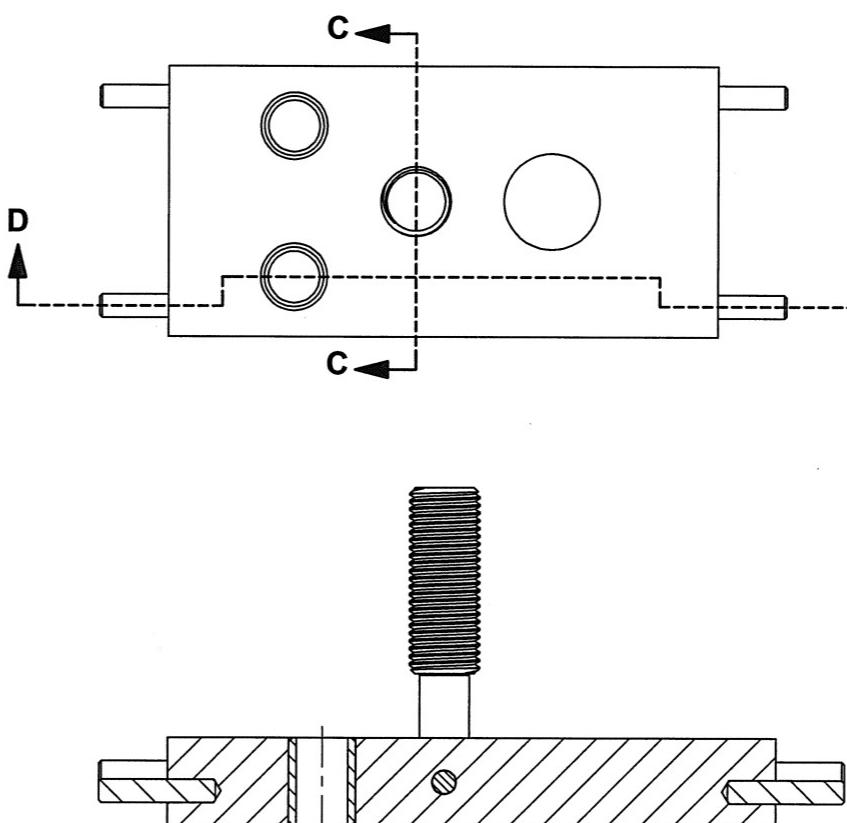
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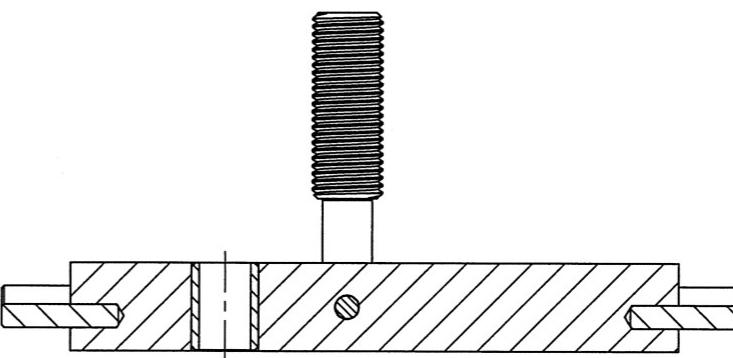
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6000G06032-6F-2	TOP PLATE
-3	2	RBW6000G06032-6F-3	TOP PLATE BUSHING
-4	1	RBW6000G06032-6F-4	TOP PLATE SCREW
27	4	MS16555-328	PHOSPHATE STEEL DOWEL PIN 1/8" DIA. X 5/8" LG.
28	2	MS21209C0820	SS HELICAL INSERT #8-32 X 0.328" LG.
29	1	MS16555-332	PHOSPHATE PLATED STEEL DOWEL PIN 1/8" DIA. X 1-1/4" LG.



RBW6000G06032-6F-1 TOP PLATE ASSY



SECTION C-C



SECTION D-D

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 29, ITEM 27 AND ITEM -3 WITH ITEM -2, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED	<i>[Signature]</i>	TITLE
DATE 2019-08-13		RADIAL PLAY CHECK TOOL
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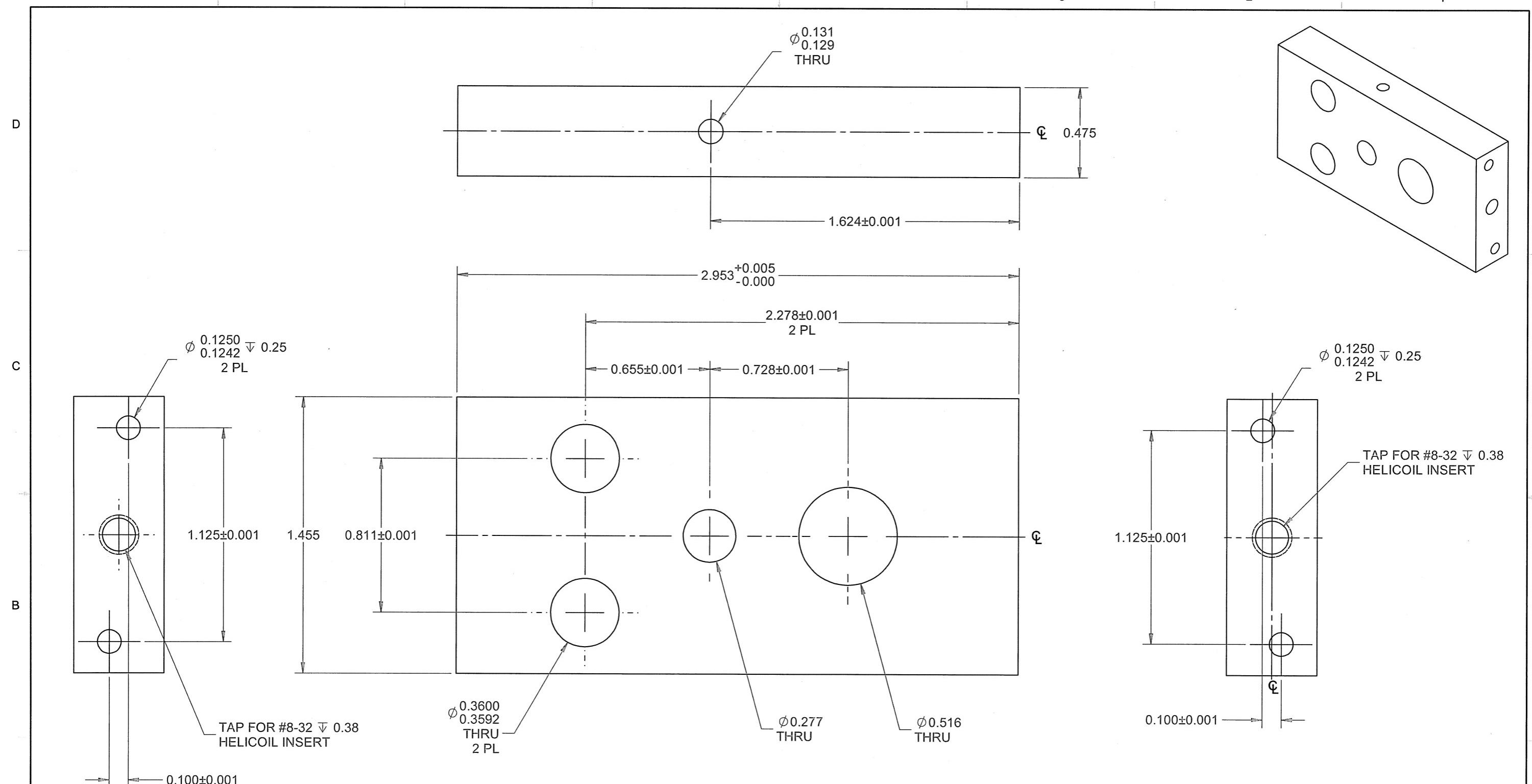
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RBW6000G06032-6F-2 TOP PLATE

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	VM VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	REV. A	
APPROVED	<i>[Signature]</i>	TOOL PART # RBW6000G06032-6F	
DATE 2019-08-13		TITLE RADIAL PLAY CHECK TOOL	
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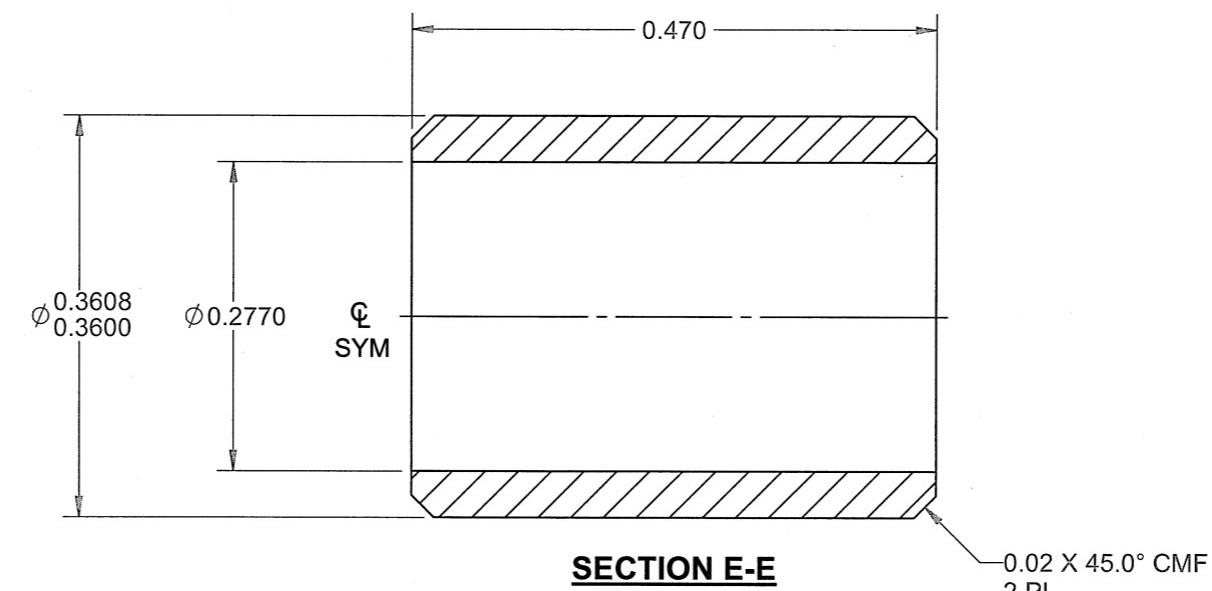
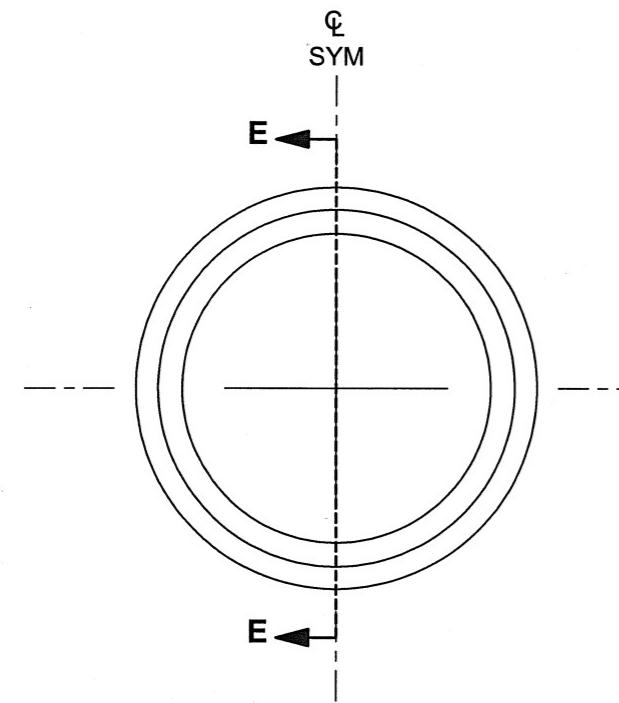
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RBW6000G06032-6F-3 TOP PLATE BUSHING

NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	WJ		
DATE 2019-08-13		TOOL PART # RBW6000G06032-6F	
		TITLE RADIAL PLAY CHECK TOOL	
		SCALE NTS	
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REV. A

SHEET 5 OF 23

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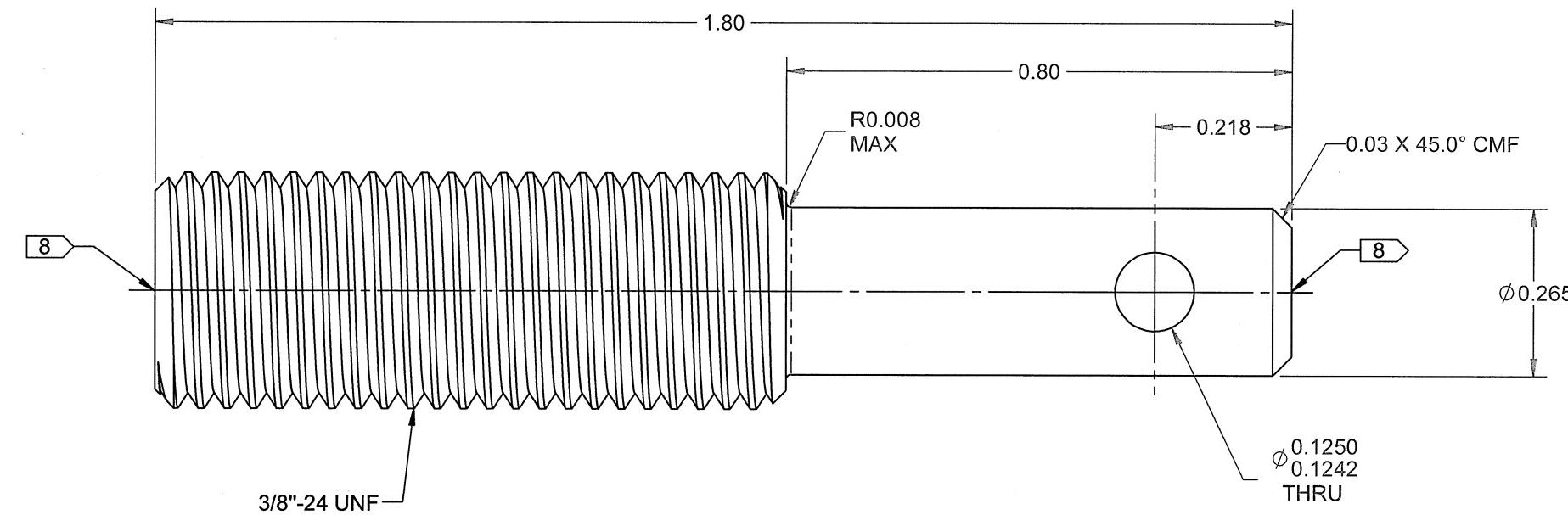
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RBW6000G06032-6F-4 TOP PLATE SCREW

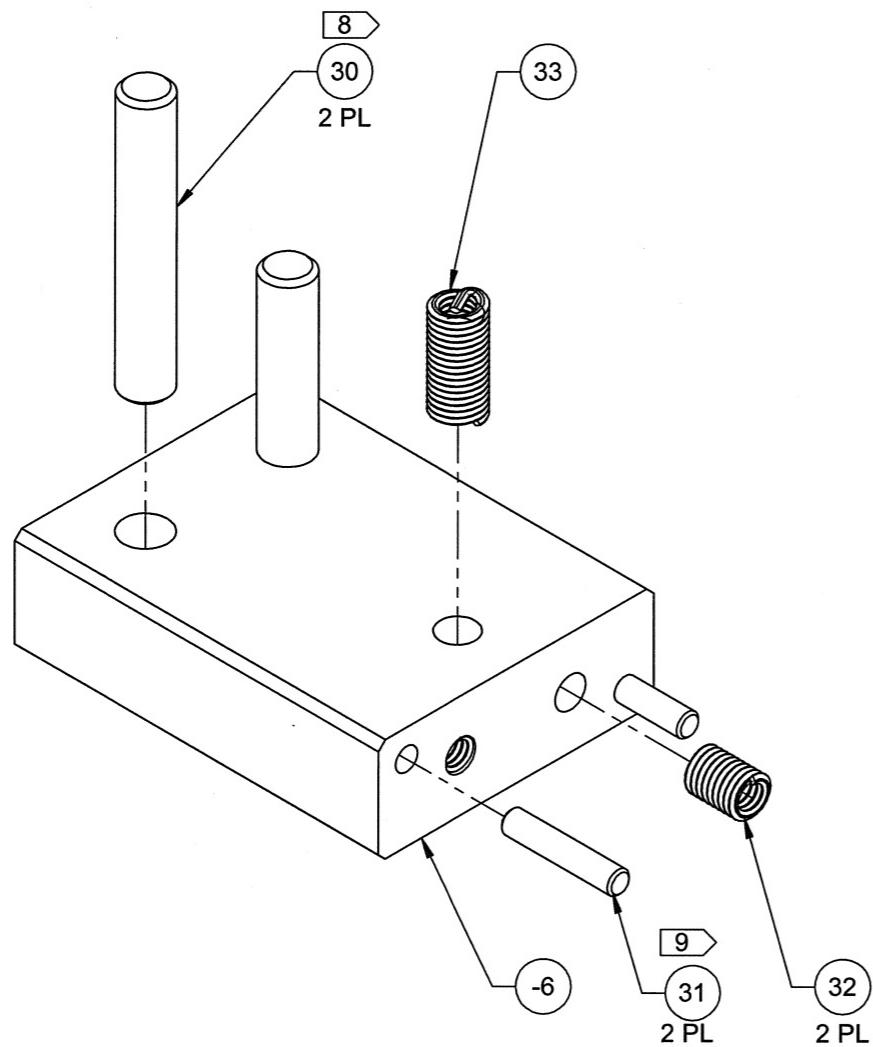
NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV. A
APPROVED	WJ	RBW6000G06032-6F	SHEET 6 OF 23
DATE 2019-08-13		TITLE RADIAL PLAY CHECK TOOL	
SCALE NTS			

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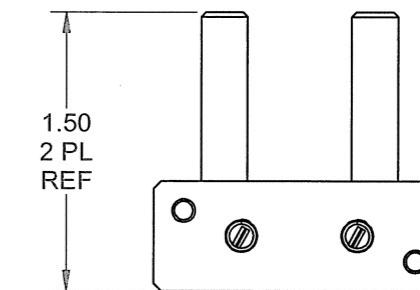
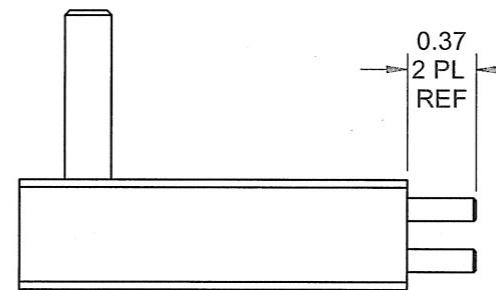
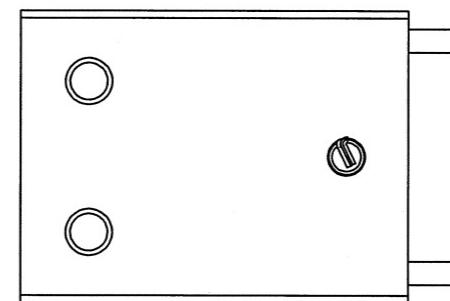
ITEM #	QTY	PART #	PART TITLE
-6	1	RBW6000G06032-6F-6	SLIDING TOP PLATE
30	2	MS16555-350	PHOPHATE PLATED STEEL DOWEL PIN 1/4" DIA. x 1-1/2" LG.
31	2	MS16555-328	PHOSPHATE STEEL DOWEL PIN 1/8" DIA. X 5/8" LG.
32	2	MS21209C0820	SS HELICAL INSERT #8-32 X 0.328" LG.
33	1	MS21209F1-30	SS HELICAL INSERT #10-32 X 0.570" LG.



RBW6000G06032-6F-5 SLIDING TOP PLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 30 FLUSH TO SURFACE OF ITEM -6, AND REMOVE EXCESS
- 9) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 31 WITH ITEM -6, AND REMOVE EXCESS



DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	FK
APPROVED	<i>[Signature]</i>

DATE 2019-08-13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBW6000G06032-6F

REV. A

SHEET 7 OF 23

TITLE
RADIAL PLAY CHECK TOOL

SCALE
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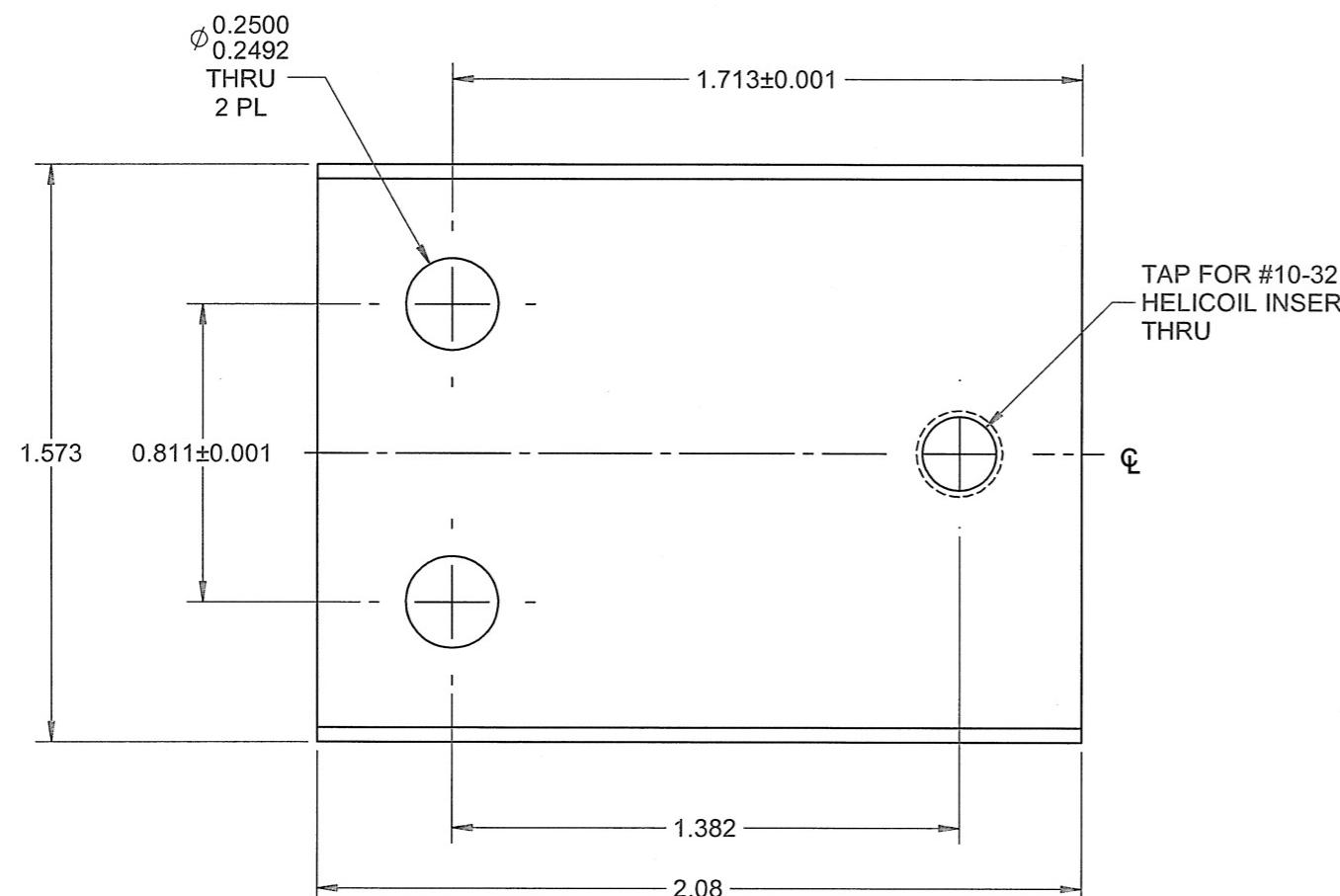
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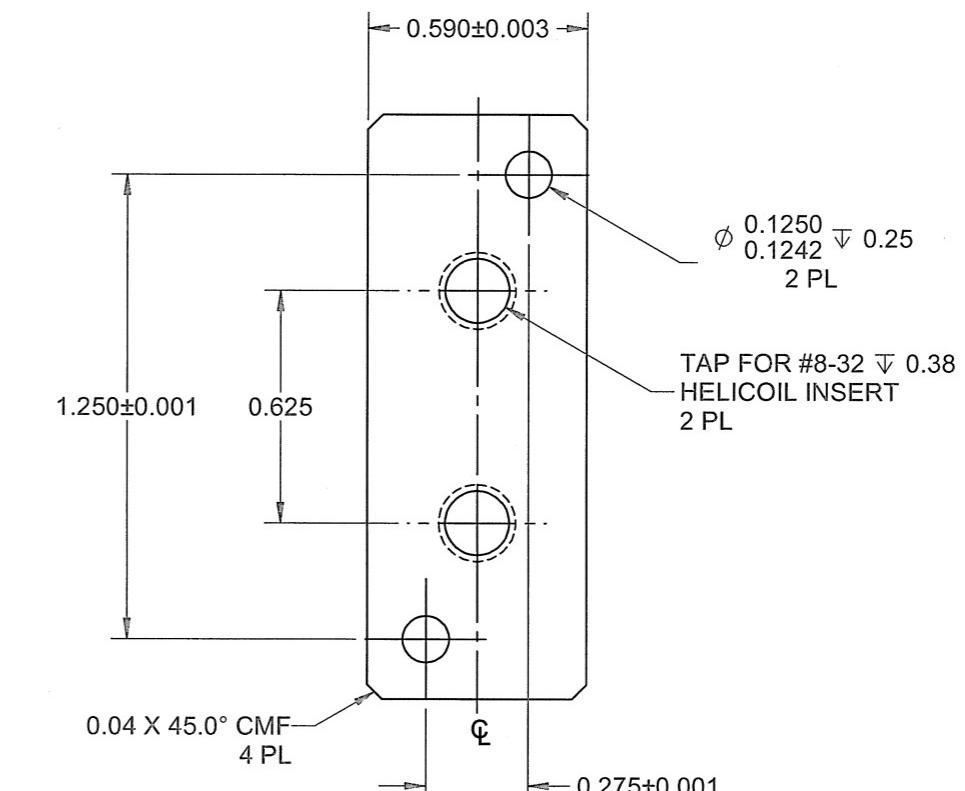
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RBW6000G06032-6F-6 SLIDING TOP PLATE



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK	REV. A	
APPROVED	<i>[Signature]</i>	TOOL PART #	
RBW6000G06032-6F			
TITLE			
RADIAL PLAY CHECK TOOL			
DATE 2019-08-13			
SCALE NTS			
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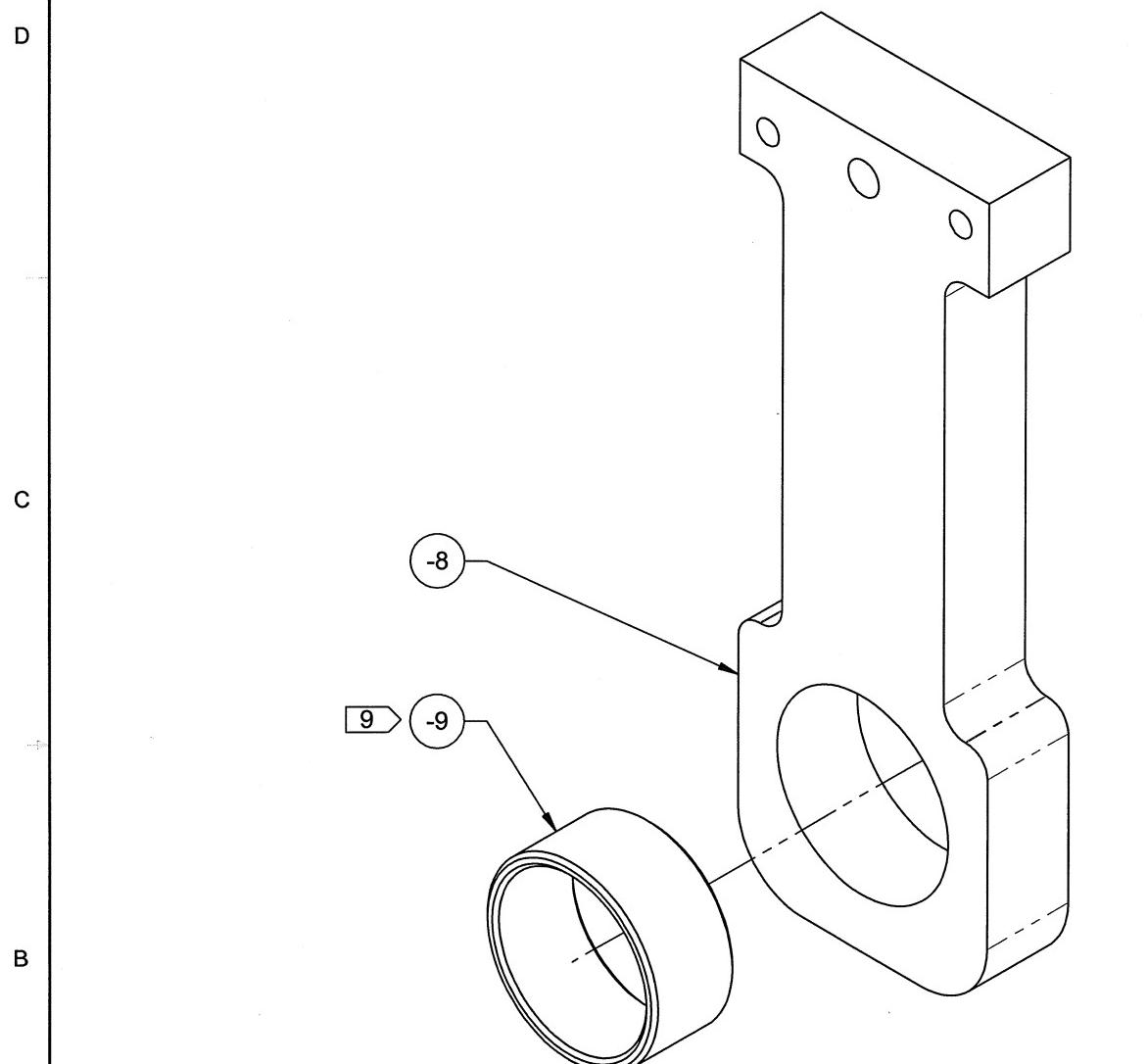
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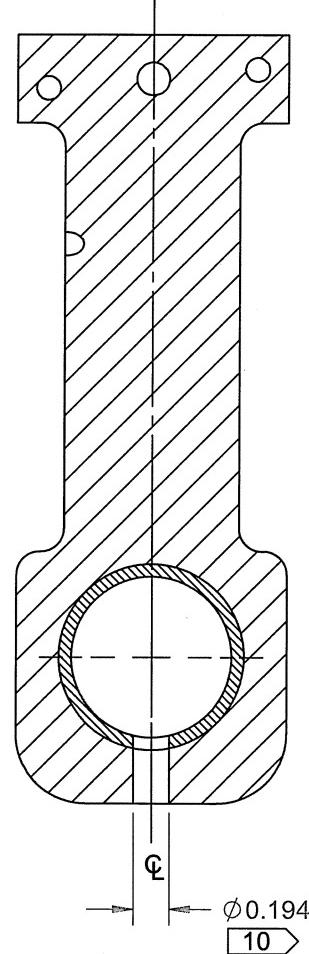
ITEM #	QTY	PART #	PART TITLE
-8	1	RBW6000G06032-6F-8	ALIGNMENT SIDE PLATE
-9	1	RBW6000G06032-6F-9	ALIGNMENT SIDE PLATE BUSHING



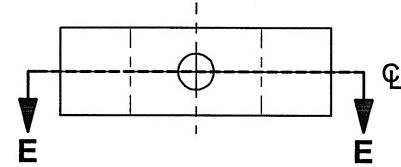
RBW6000G06032-6F-7 ALIGNMENT SIDE PLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL SHARP EDGES AND BURRS
- 9) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -9 FLUSH TO SURFACE OF ITEM -8, AND REMOVE EXCESS
- 10) TRANSFER DRILL HOLE THROUGH ITEMS -8 AND -9 AS SHOWN



SECTION E-E



DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED	WAP	TITLE
DATE 2019-08-13		RADIAL PLAY CHECK TOOL
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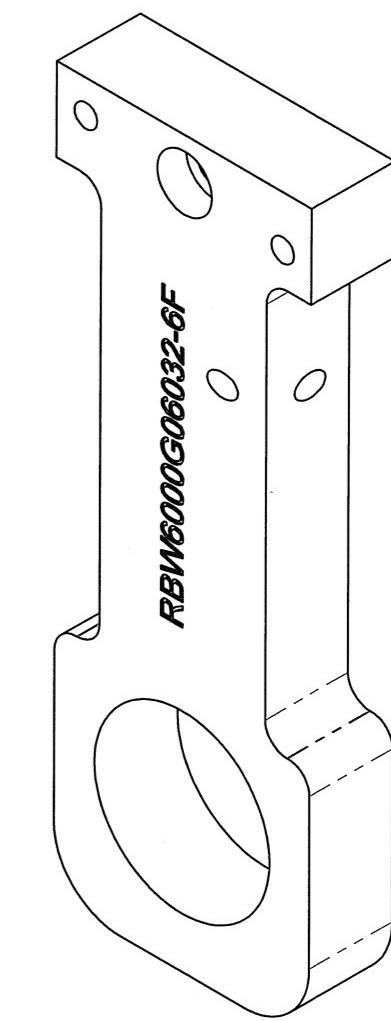
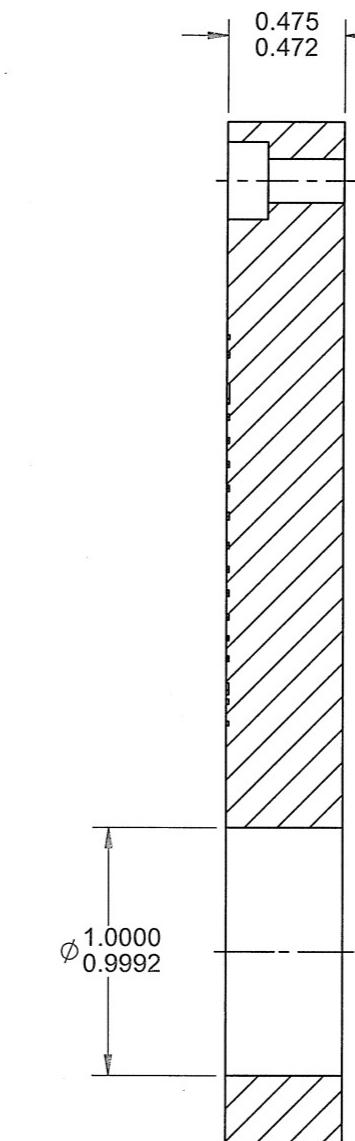
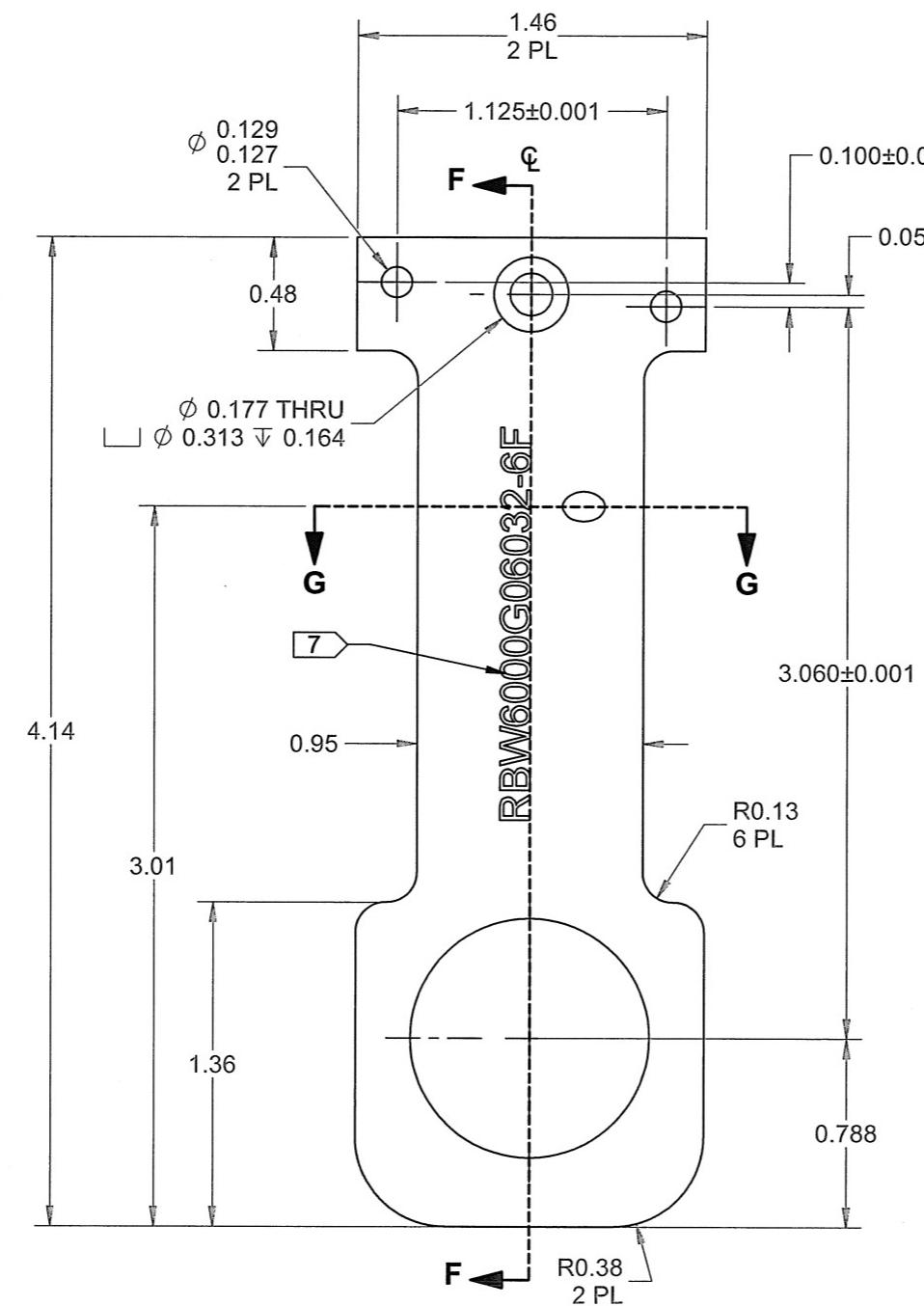
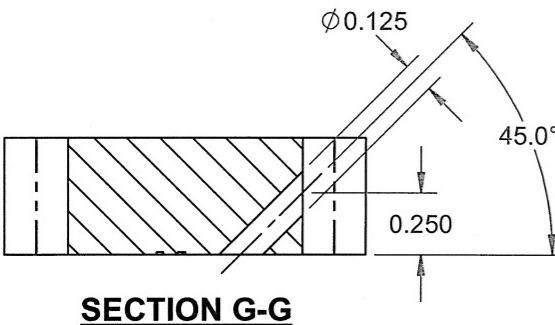
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**NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6000G06032-6F", AS SHOWN

DESIGN DRAWN	VM VM	DART AEROSPACE LTD
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	FK	REV. A
APPROVED	<i>[Signature]</i>	TOOL PART # RBW6000G06032-6F SHEET 10 OF 23
DATE 2019-08-13		TITLE RADIAL PLAY CHECK TOOL
SCALE NTS		

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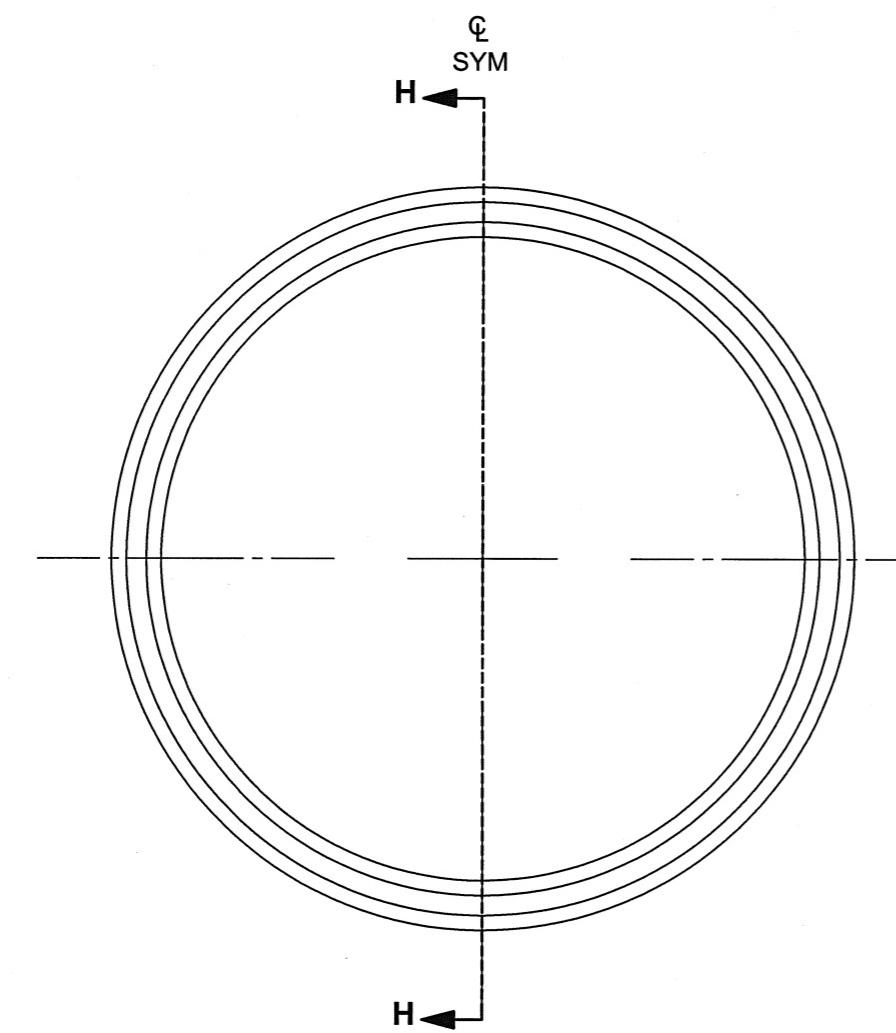
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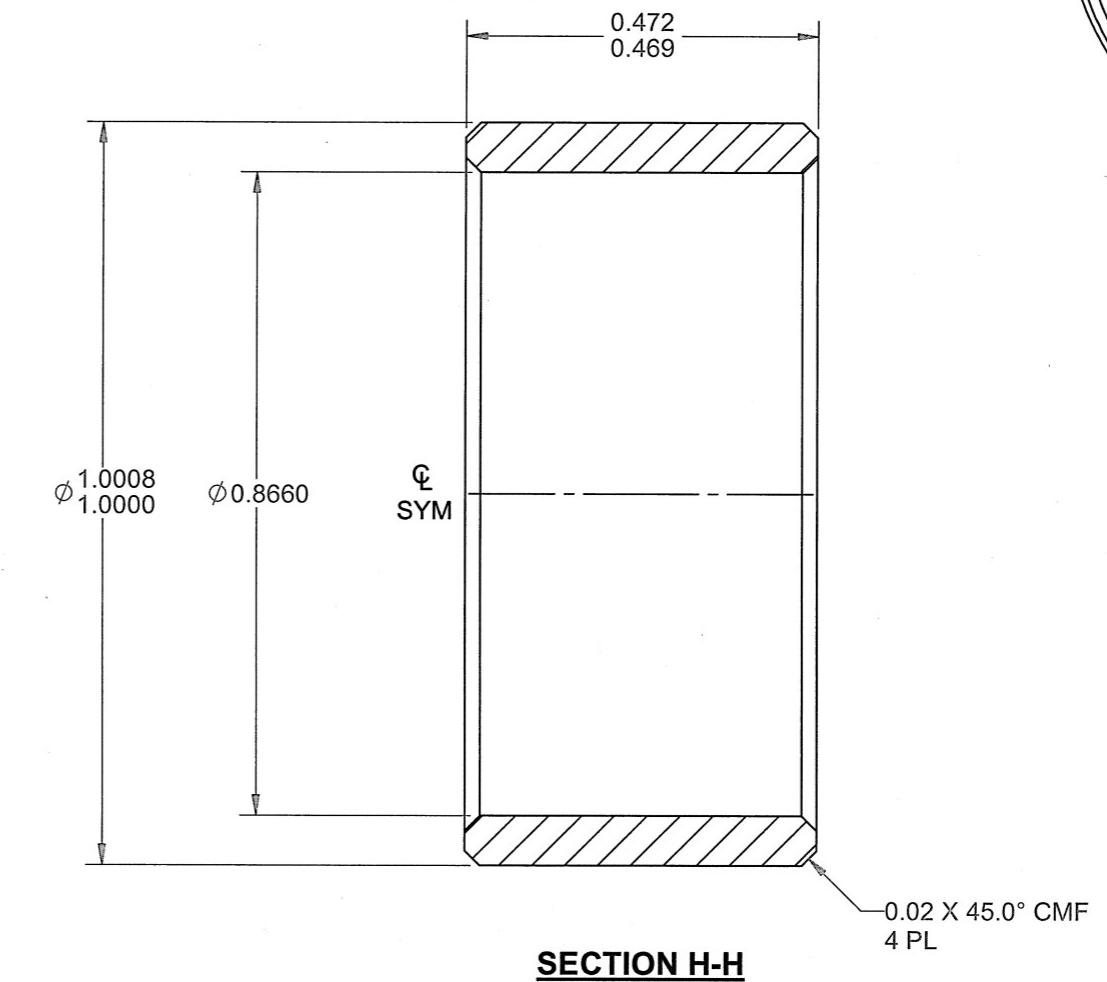
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RBW6000G06032-6F-9 ALIGNMENT SIDE PLATE BUSHING



SECTION H-H

NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	
APPROVED	WJ	

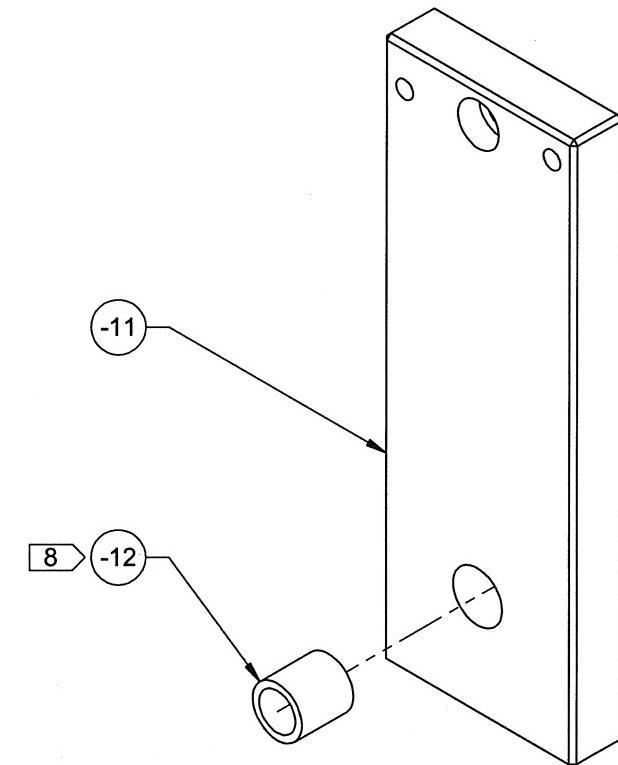
TOOL PART # **RBW6000G06032-6F** REV. A
 TITLE **RADIAL PLAY CHECK TOOL** SHEET 11 OF 23
 DATE 2019-08-13 SCALE NTS

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ITEM #	QTY	PART #	PART TITLE
-11	1	RBW6000G06032-6F-11	ALIGNMENT PLATE
-12	1	RBW6000G06032-6F-12	ALIGNMENT PLATE BUSHING

D

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -12 FLUSH TO SURFACE OF ITEM -11, AND REMOVE EXCESS

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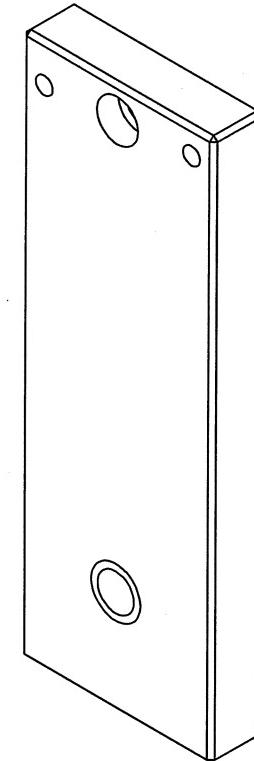
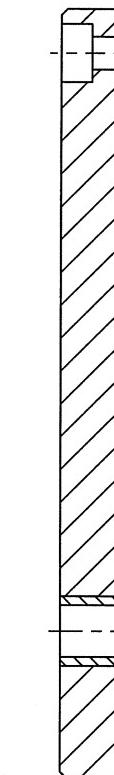
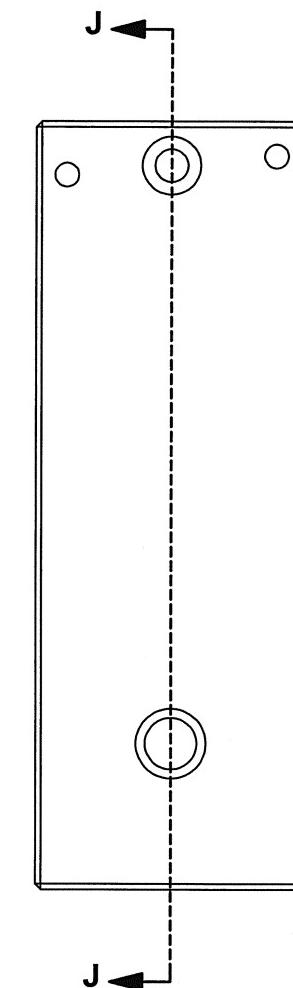
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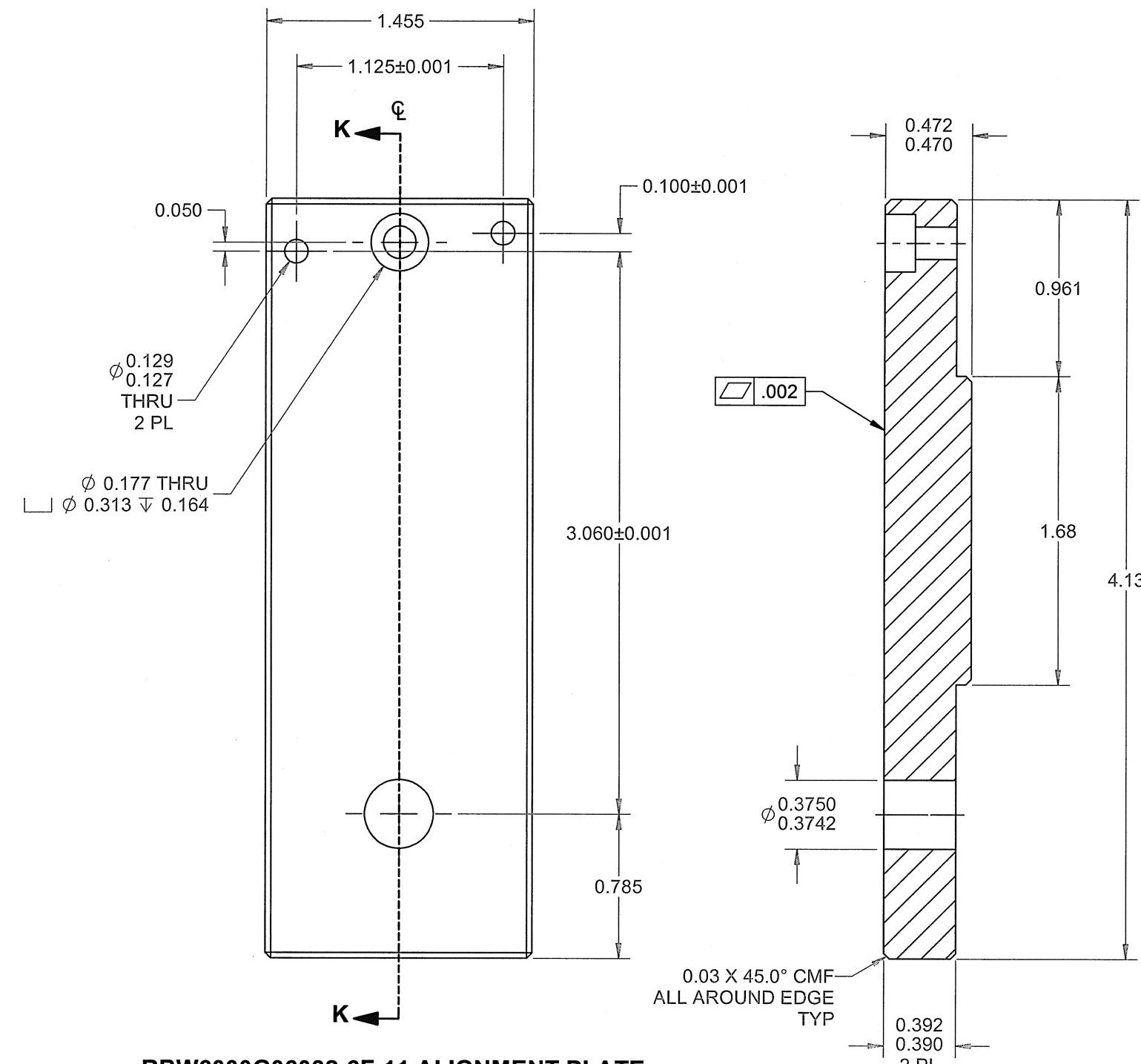
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**SECTION J-J****RBW6000G06032-6F-10 ALIGNMENT PLATE ASSY**

DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED	V/P	TITLE
DATE 2019-08-13		RADIAL PLAY CHECK TOOL
REV. A		
SHEET 12 OF 23		
SCALE NTS		
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RBW6000G06032-6F-11 ALIGNMENT PLATE

SECTION K-K

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G06032-6F	SHEET 13 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	2019-08-13	RADIAL PLAY CHECK TOOL	NTS

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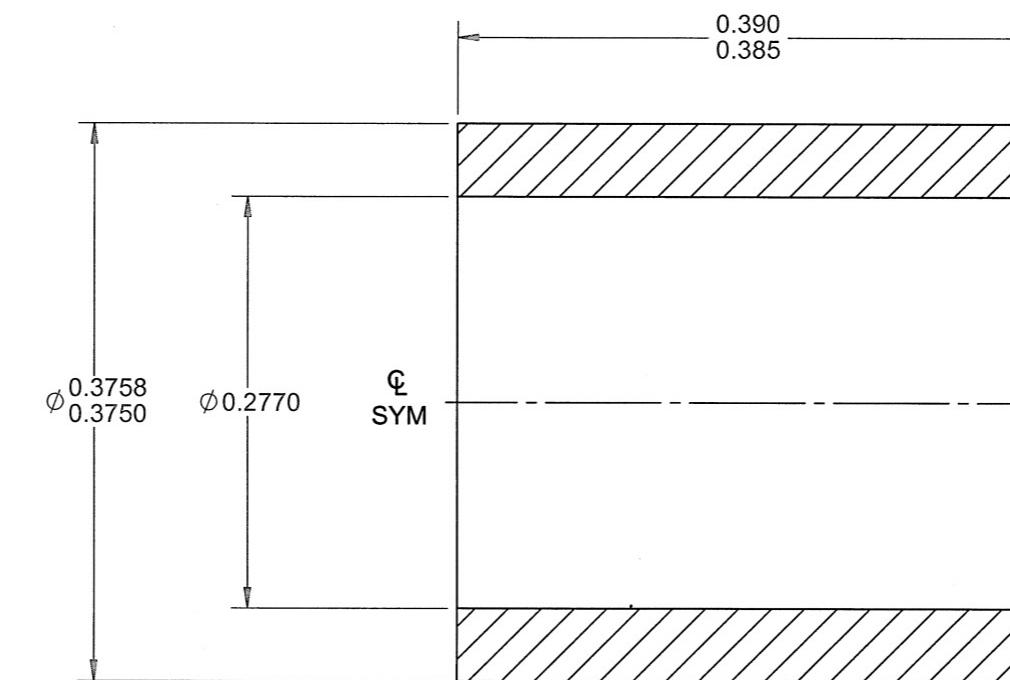
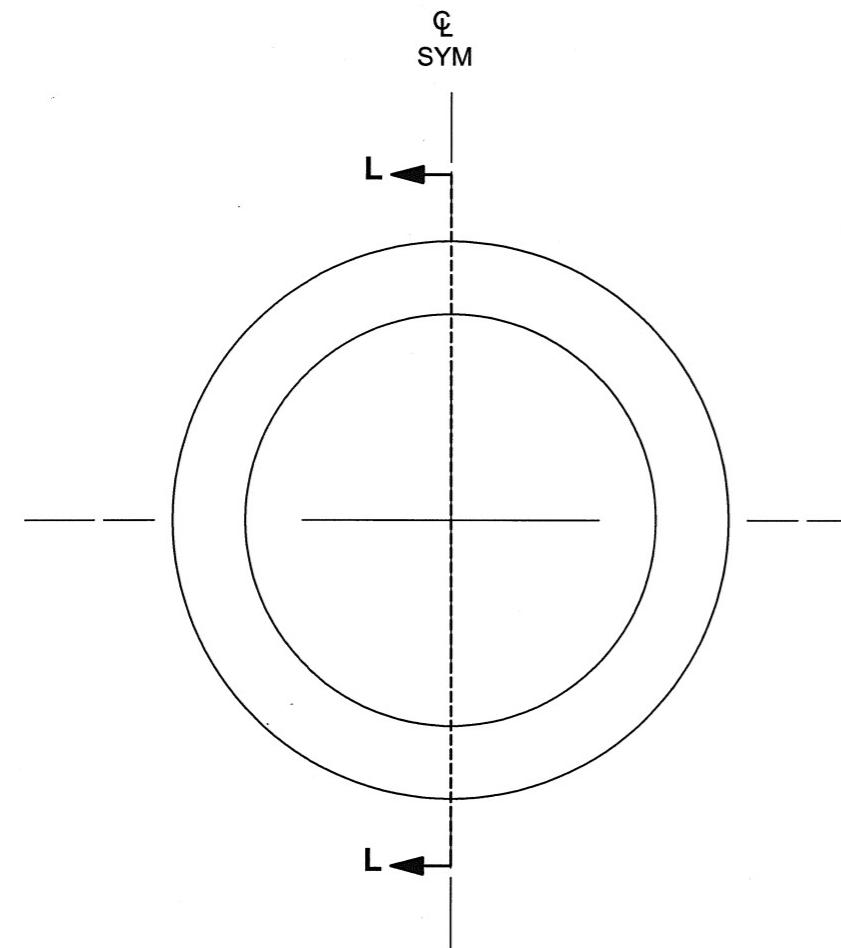
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RBW6000G06032-6F-12 ALIGNMENT PLATE BUSHING

NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	<i>[Signature]</i>		
DATE 2019-08-13		REV. A	
TOOL PART #		SHEET 14 OF 23	
RBW6000G06032-6F		TITLE	
SCALE		RADIAL PLAY CHECK TOOL	
NTS		NTS	

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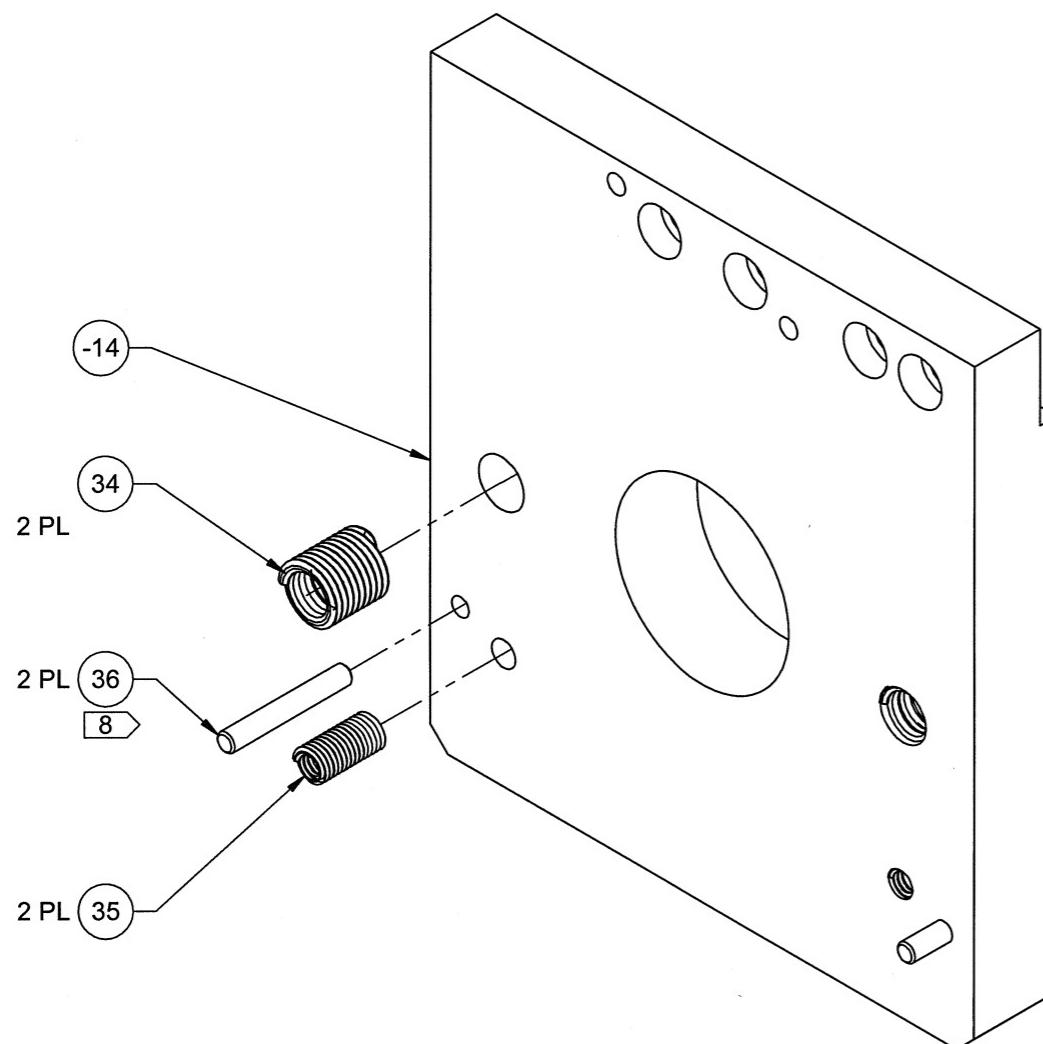
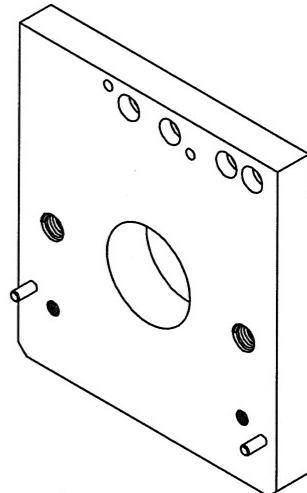
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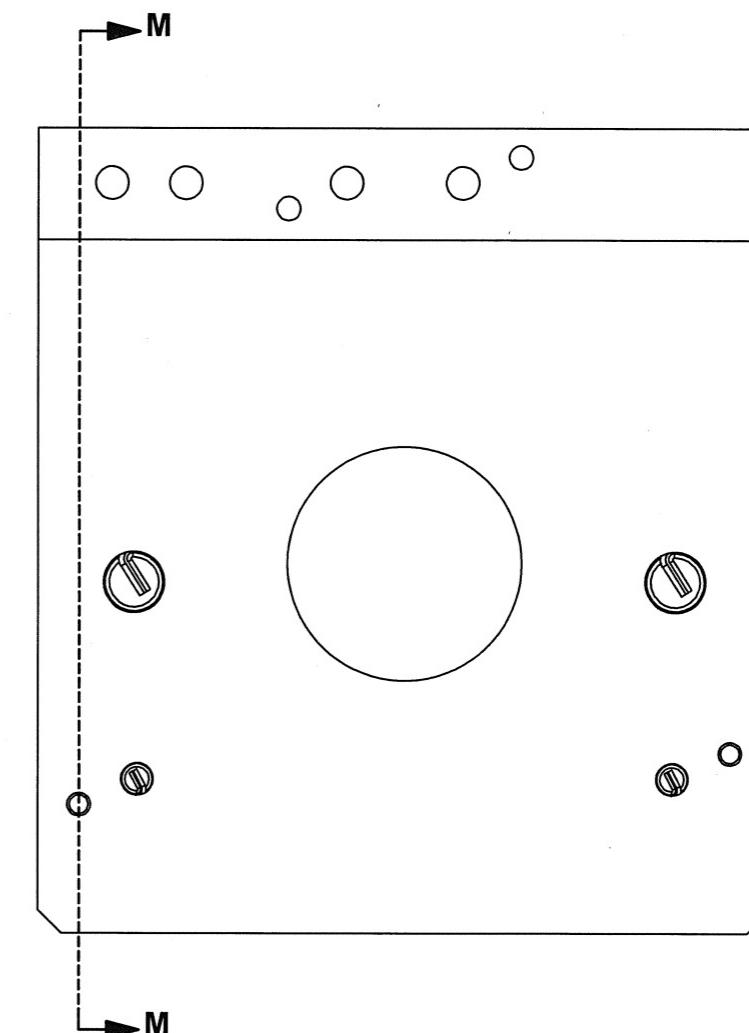
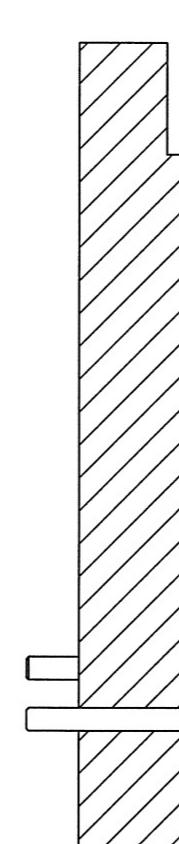
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ITEM #	QTY	PART #	PART TITLE
-14	1	RBW6000G06032-6F-14	SLIDING SIDE PLATE
34	2	MS21209F5-15	SS HELICAL INSERT 5/16"-24 X 0.469" LG.
35	2	MS21209C0830	SS HELICAL INSERT #8-32 X 0.492" LG.
36	2	MS16555-330	PHOSPHATE PLATED STEEL DOWEL PIN 1/8" DIA. x 7/8" LG.

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RBW6000G06032-6F-13 SLIDING SIDE PLATE ASSY

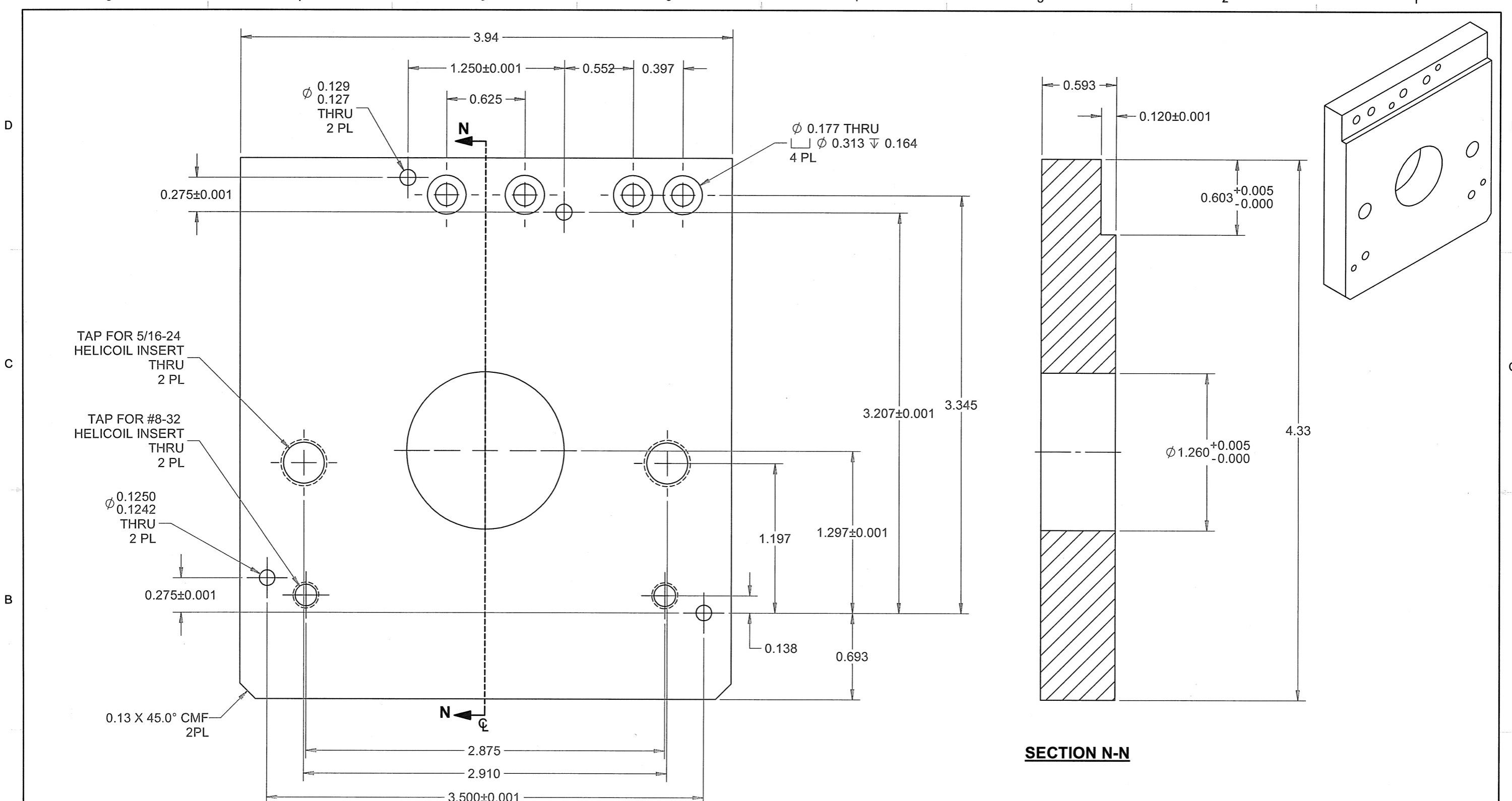


SECTION M-M

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = \pm 0.1"$ / $\pm 1^\circ$
 $X.XX = \pm 0.01"$ / $\pm 0.5^\circ$
 $X.XXX = \pm 0.005"$ / $\pm 0.1^\circ$
 $X.XXXX = \pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 36 FLUSH TO SURFACE OF ITEM -14, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	<i>[Signature]</i>		
DATE 2019-08-13		REV. A	
TOOL PART # RBW6000G06032-6F		SHEET 15 OF 23	
TITLE RADIAL PLAY CHECK TOOL		SCALE NTS	
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SECTION N-N

NOTES:

2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: $\pm 0.1''$ / $\pm 1^\circ$

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X XXXX = +/- 0.005" / +/- 0.1°

X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.0"
 PARALLELISM, ECCENTRICITY

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

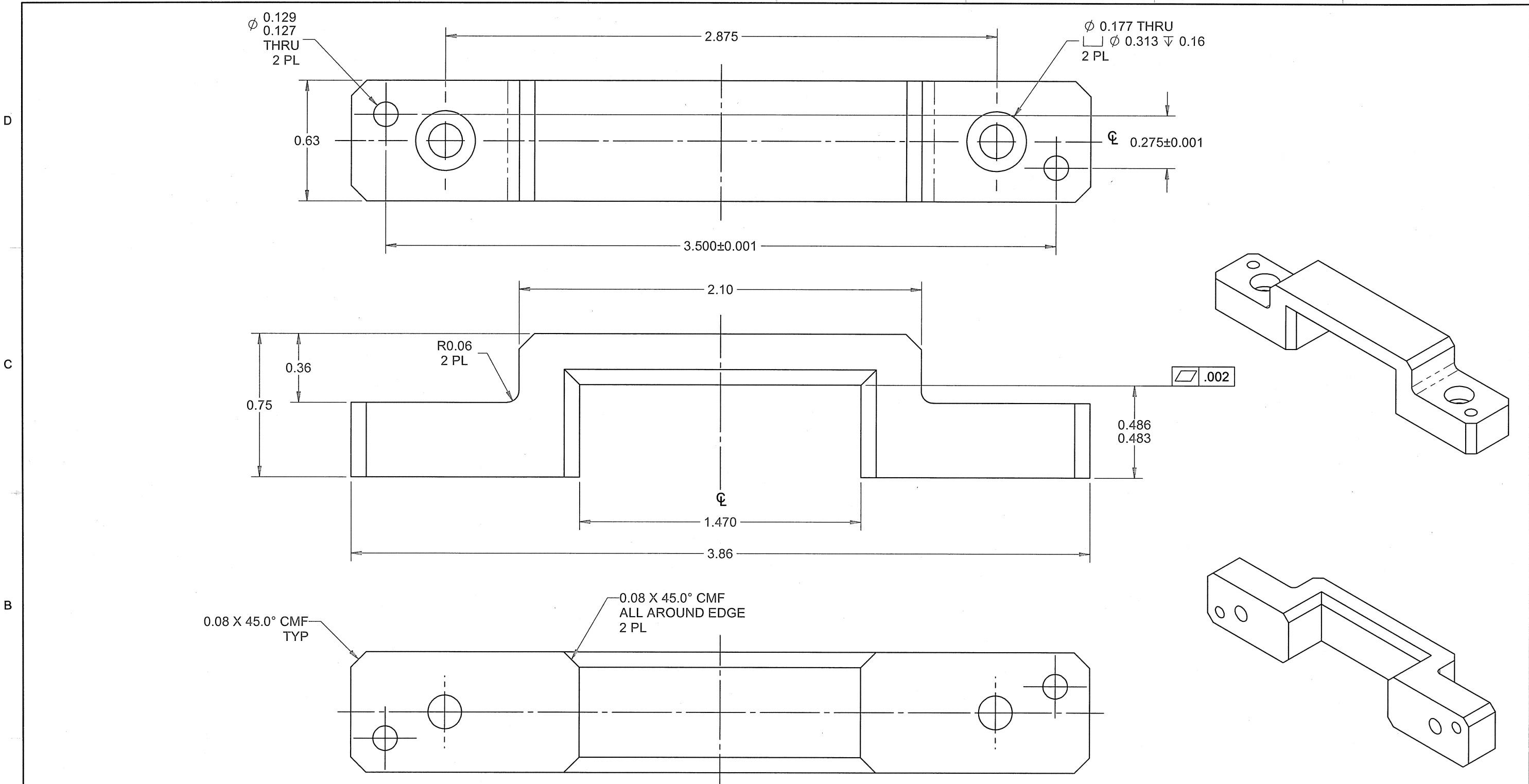
7) IDENTIFICATION: N/A

RBW6000G06032-6F-14 SLIDING SIDE PLATE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G06032-6F	SHEET 16 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	2019-08-13	RADIAL PLAY CHECK TOOL	NTS

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RBW6000G06032-6F-15 SLIDING ALIGNMENT

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED		REV. A
		SHEET 17 OF 23
		SCALE NTS
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DATE 2019-08-13

TITLE RADIAL PLAY CHECK TOOL

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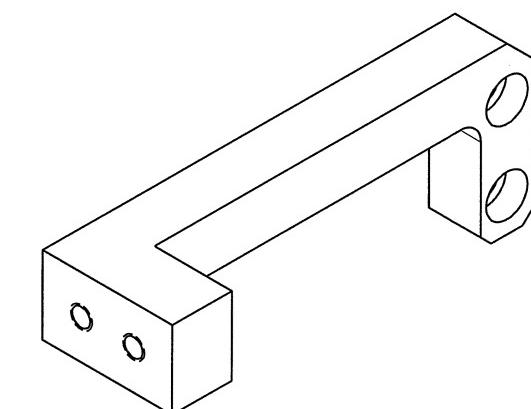
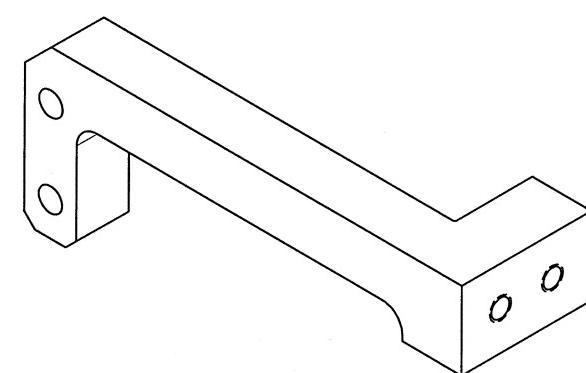
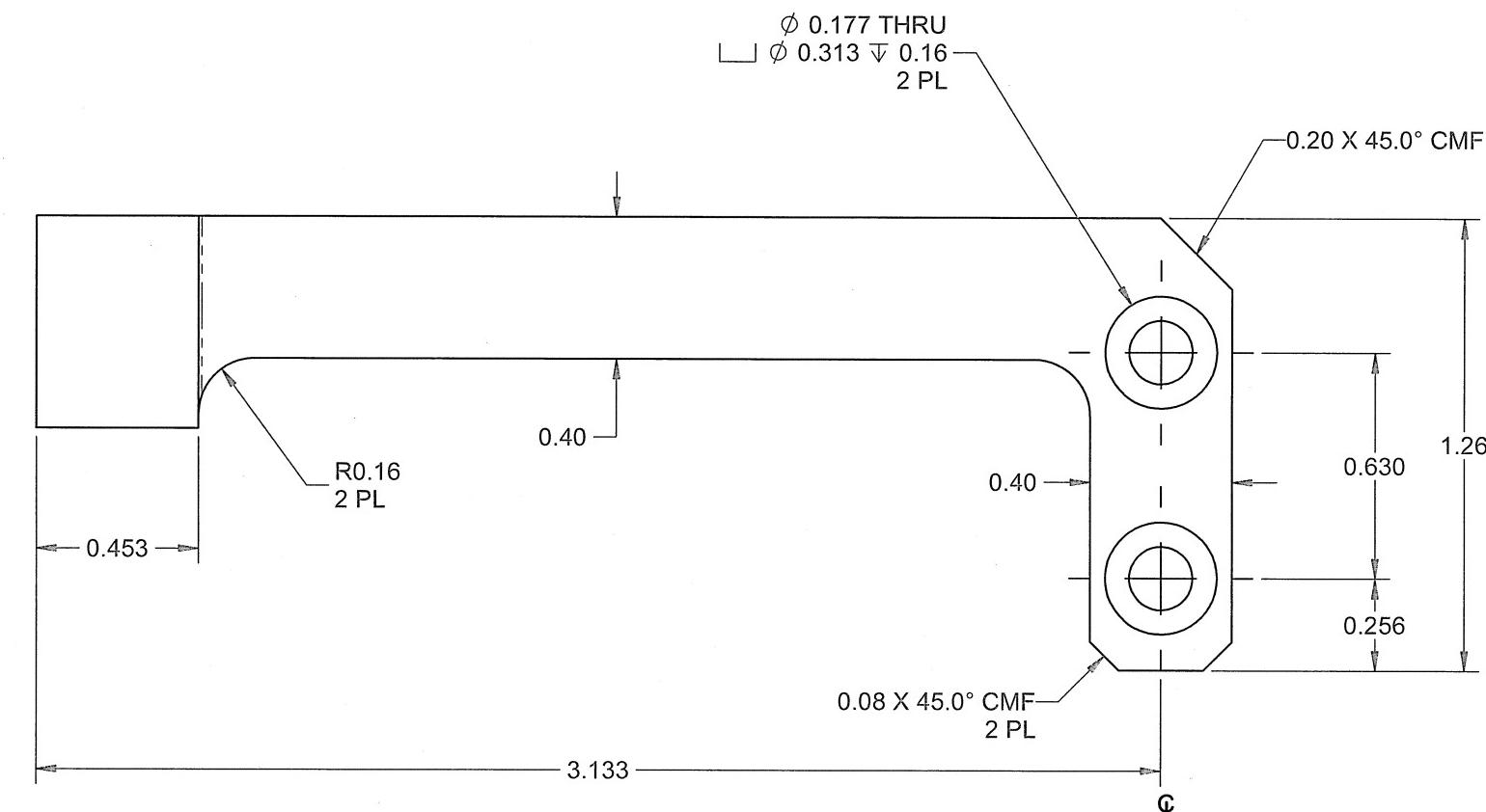
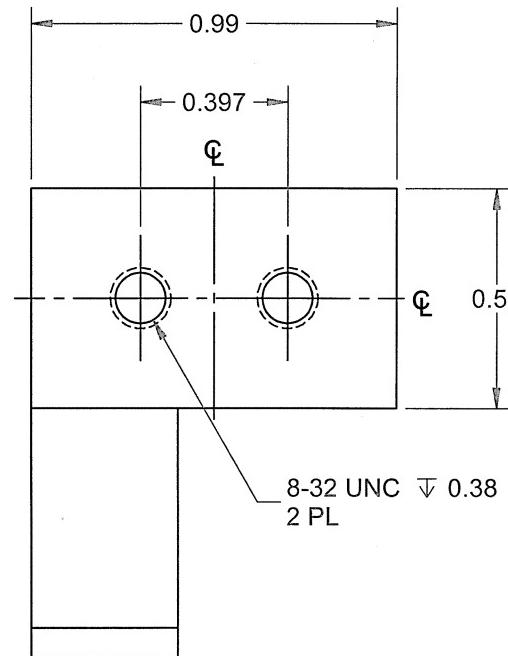
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RBW6000G06032-6F-16 EXTENSION ARM

NOTES:

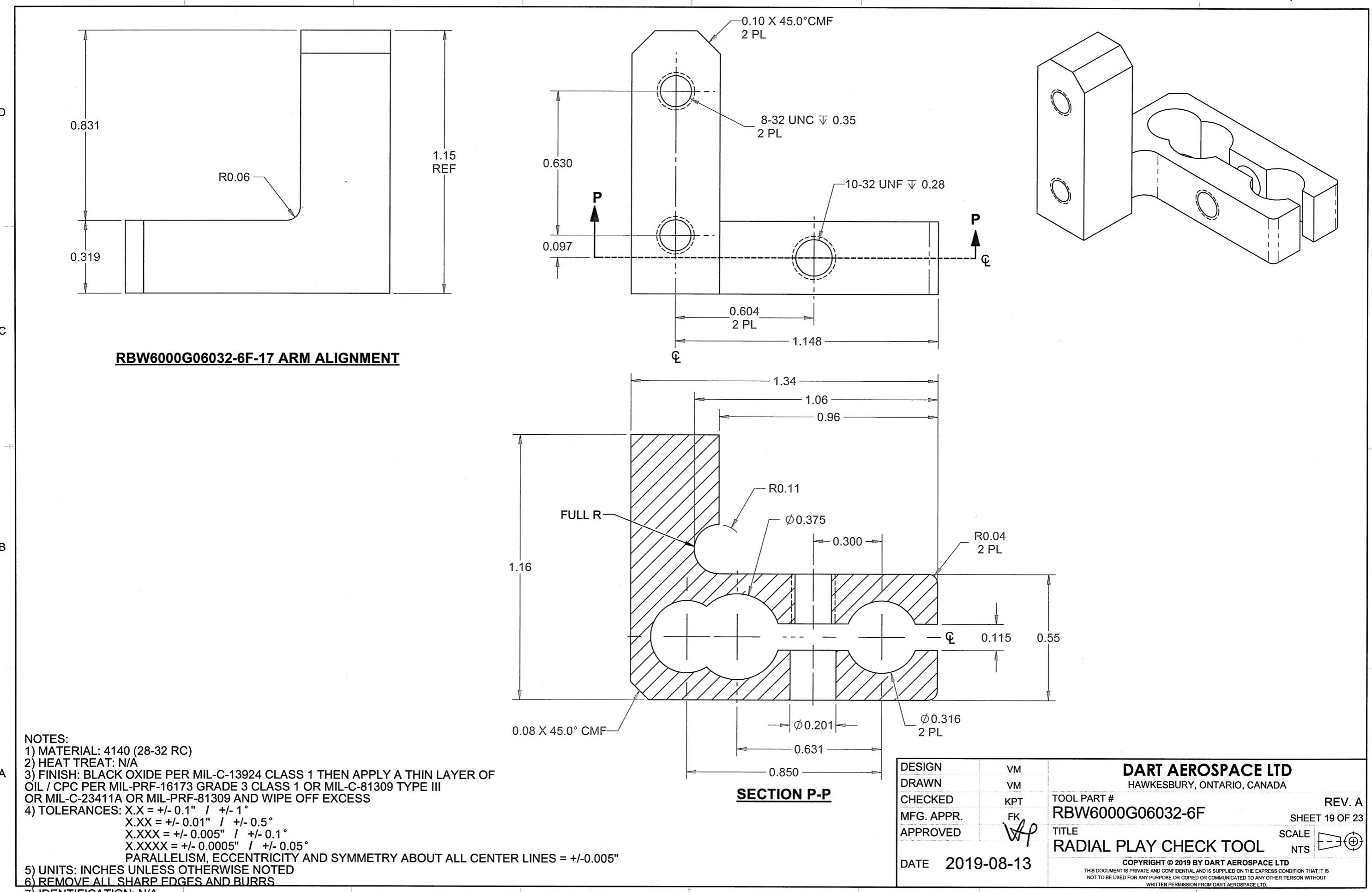
- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

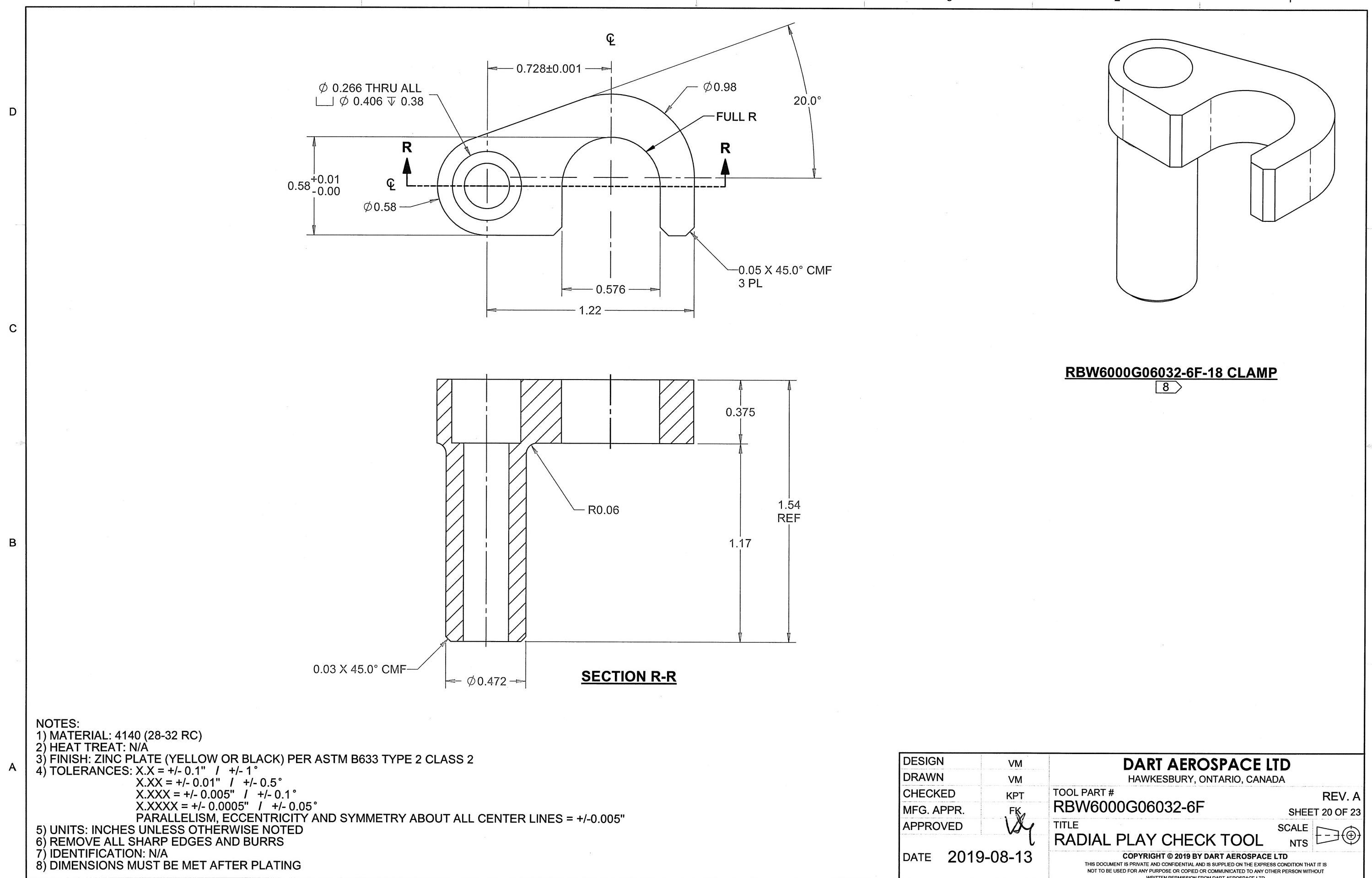
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED	<i>[Signature]</i>	REV. A
DATE 2019-08-13		SHEET 18 OF 23
TITLE RADIAL PLAY CHECK TOOL		SCALE NTS
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DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED	<i>[Signature]</i>	REV. A
DATE 2019-08-13		SHEET 20 OF 23
		SCALE NTS
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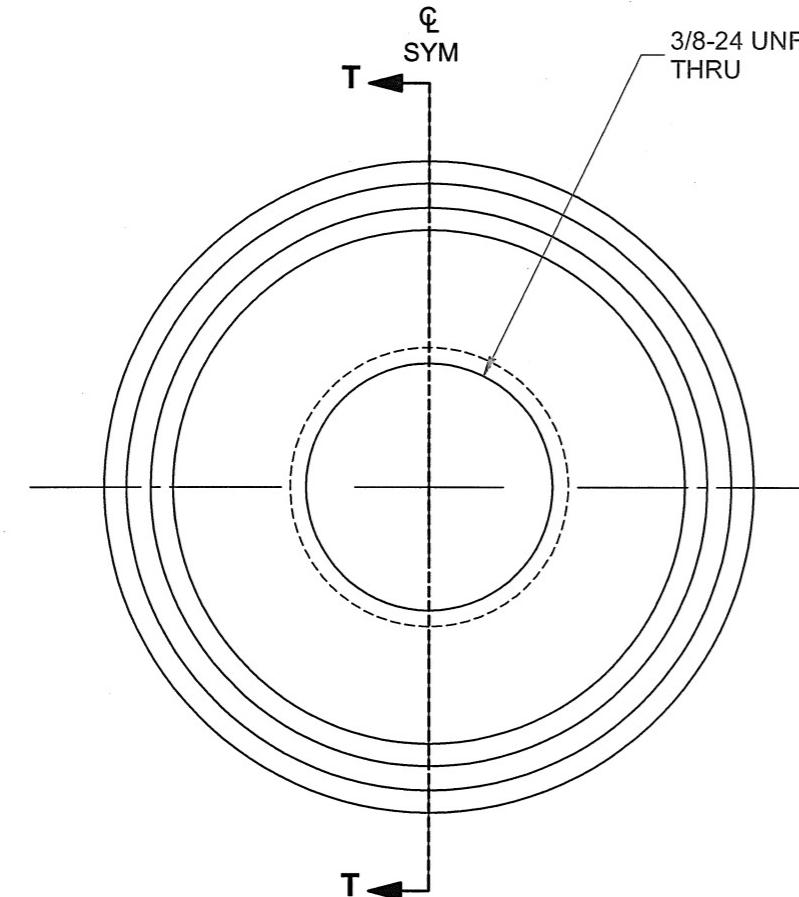
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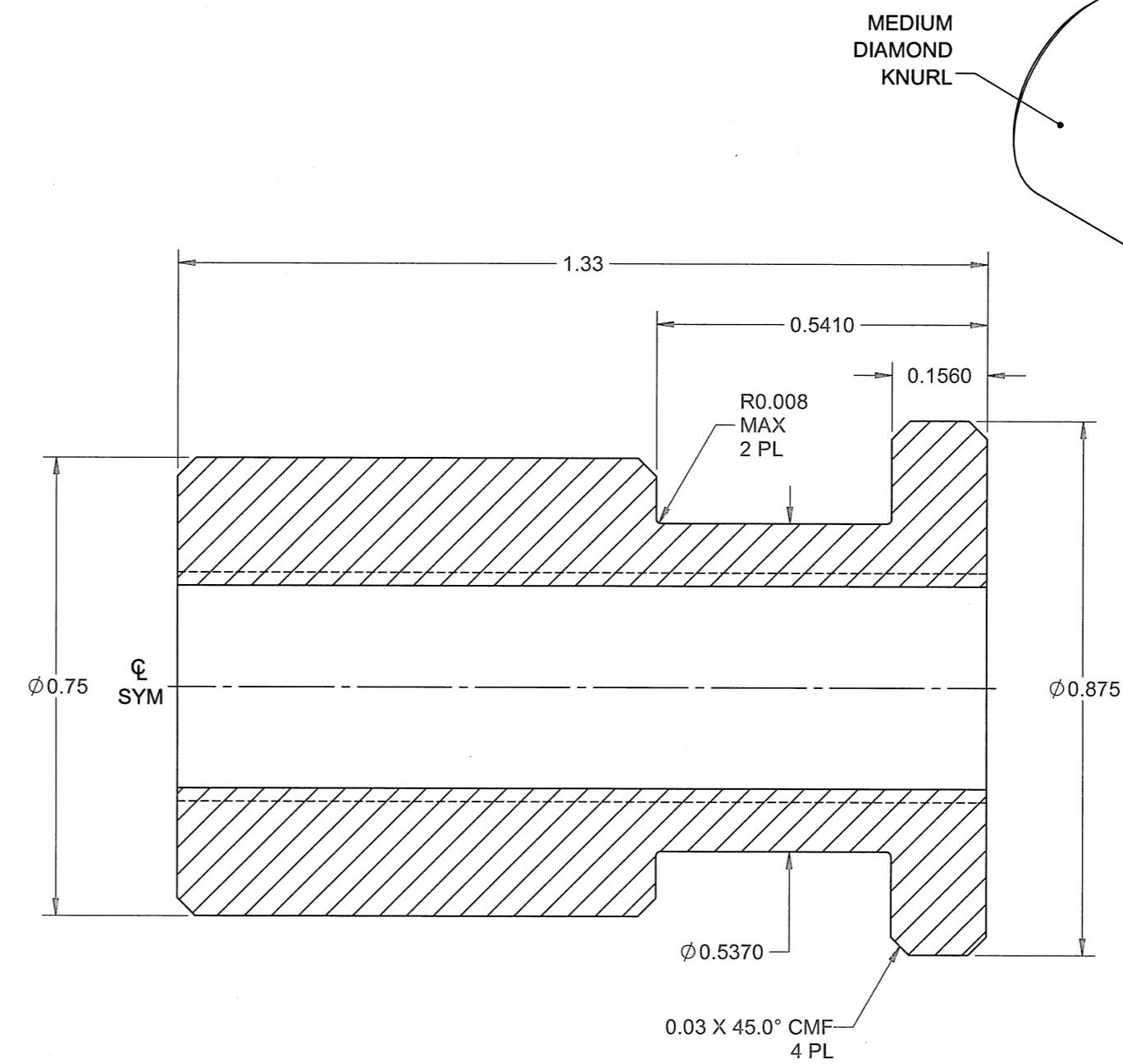
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RBW6000G06032-6F-19 ADJUSMENT NUT



SECTION T-T

NOTES:-

- NOTES:

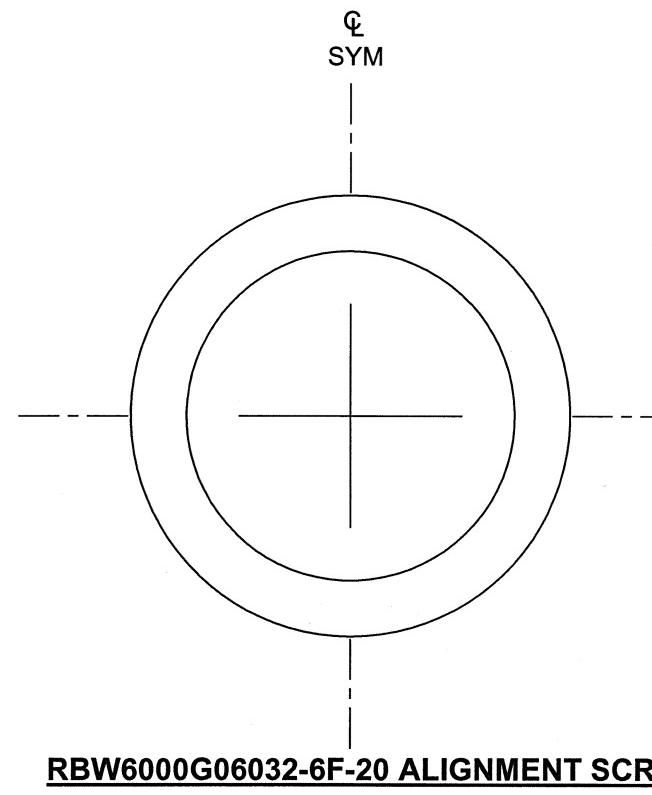
 - 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A SHEET 21 OF 23
MFG. APPR.	FK		
APPROVED	<i>WJ</i>	TITLE	SCALE NTS
DATE	2019-08-13		
RBW6000G06032-6F RADIAL PLAY CHECK TOOL			
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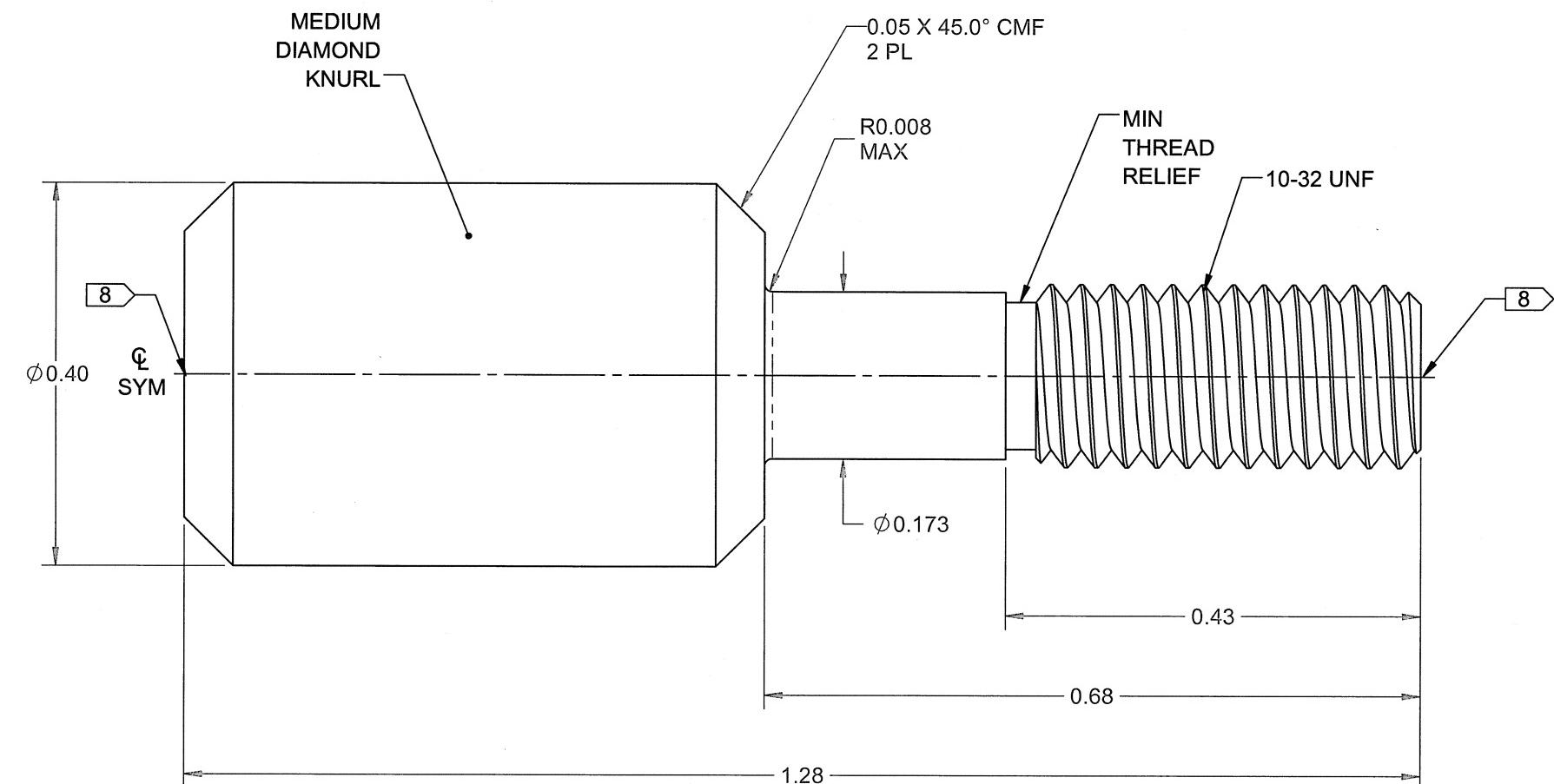
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RBW6000G06032-6F-20 ALIGNMENT SCREW



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	
APPROVED		<i>[Signature]</i>
TOOL PART #		
RBW6000G06032-6F		
TITLE		
RADIAL PLAY CHECK TOOL		
DATE	2019-08-13	
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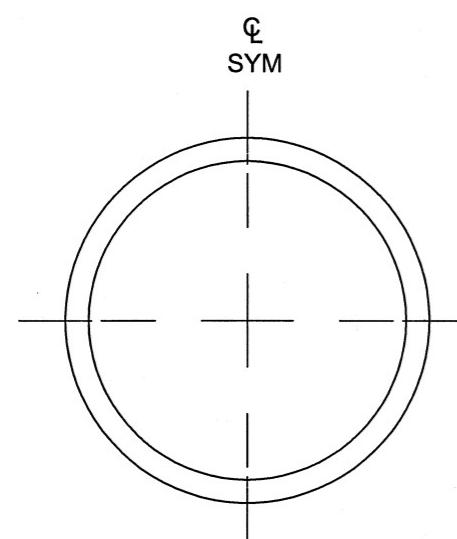
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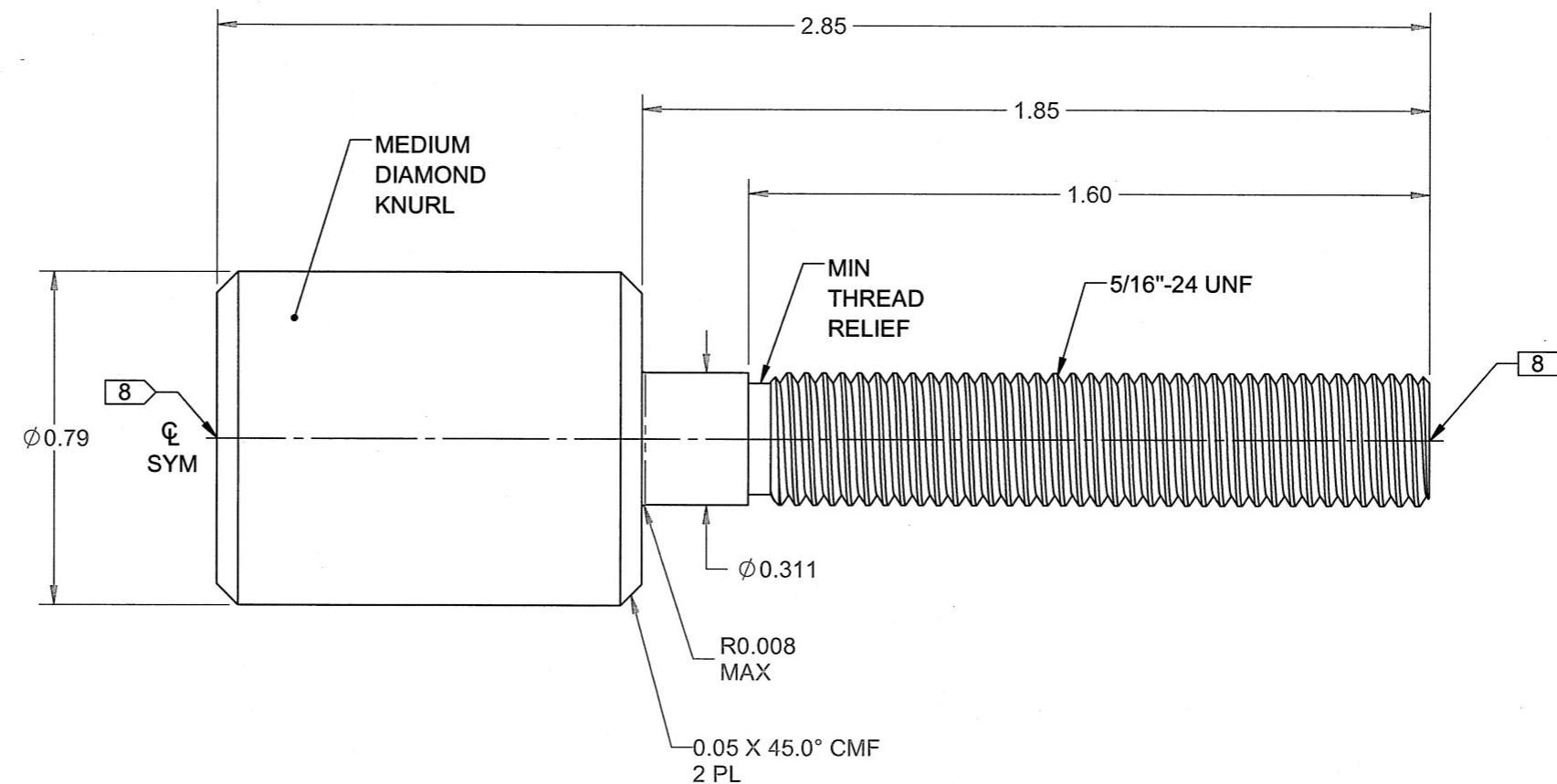
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RBW6000G06032-6F-21 SCREW



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G06032-6F
APPROVED	WF	REV. A
		SHEET 23 OF 23
		TITLE
		RADIAL PLAY CHECK TOOL
		SCALE NTS
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